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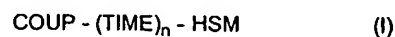
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(54) **Color photographic element containing a coupler releasing derivative with at least three heteroatoms with specific hydrophobicity**

(57) Disclosed is a color photographic element comprising at least one light sensitive silver halide emulsion layer having associated therewith a coupler according to Formula I:



wherein:

COUP is an organic fragment which reacts with oxidized developer to release  $-(\text{TIME})_n - \text{HSM}$ ,  
TIME is an optional timing group or linking group which connects HSM to COUP at the site of reaction with oxidized developer,  
 $n = 0, 1$  or  $2$ , and

HSM is a compound having a minimum of three heteroatoms and having a ClogP sufficient to increase the speed of said element compared to the same element without the coupler.

The invention provides improved light sensitivity without significant adverse effect on granularity or ease of manufacture.

**EP 1 072 952 A1**

## Description

[0001] This invention relates to a color photographic element containing a layer with a light sensitive silver halide emulsion and a coupler that releases a speed improving compound with at least three heteroatoms.

[0002] It is a long-standing objective of color photographic origination materials to maximize the overall response to light while maintaining the lowest possible granularity. Increased photographic sensitivity to light (commonly referred to as photographic speed) allows for improved images captured under low light conditions or improved details in the shadowed regions of the image. In general, the overall light sensitivity provided by the light sensitive silver halide emulsions in such systems is determined by the size of the emulsions. Larger emulsions capture more light. Upon development, the captured light is ultimately converted into dye deposits which constitute the reproduced image. However, the granularity exhibited by these dye deposits is directly proportional to the grain size of the silver halide emulsion. Thus, larger silver halide emulsion grains have higher sensitivity to light but also lead to higher granularity in the reproduced image. It has been a long-standing problem to provide materials which maximize the response to light of a silver halide emulsion for any given grain size.

[0003] For example, it is well known that highly reactive couplers or couplers that form dyes with high extinction coefficients can maximize the response of silver halide emulsions. However, the increased amplification caused by these types of dye forming materials also directly leads to higher granularity.

[0004] It is highly desirable to provide imaging materials that would lead to increased photographic speed without having to increase the size of the light-sensitive silver halide grains

[0005] It is well known that couplers that release inhibitors of silver development upon reaction with oxidized developers are useful for controlling photographic characteristics such as granularity, sharpness and color reproduction. These couplers are typically referred to as DIRs (Developer Inhibitor Releasers). In some cases, the inhibitor of silver development is not attached directly to the coupling species, but to a linking or timing group which may delay the formation of the free inhibitor fragment. The development inhibiting fragments released from these couplers are generally either heterocycles with free thiol groups such as mercaptotetrazoles, mercaptotriazoles, mercaptooxadiazoles and mercaptothiadiazoles or nitrogen based heterocycles such as tetrazoles, triazoles, benzimidazoles and benzotriazoles. All these fragments share the common feature that they inhibit silver development in order to produce the desired effects. However, inhibition of development usually leads to loss of photographic speed and at best, results in no change in photographic speed.

[0006] Purines used as inhibitor fragments as part of a DIR are disclosed in US 3,933,500, EP 867763A1, EP 867764A1, EP 369486B1 and JP 04-2878942. JP52-154631 describes the use of certain 1,3,3a,7-tetraazaindenes as inhibitor fragments as part of a DIR. EP 220746A2 and DE 3814635A1 discloses the preparation and use of tetraazaindenes as fog inhibitors when released from oxazole type developing agents. JP 60-29390 describes the use of partially ballasted benzotriazoles as inhibitor fragments as part of a DIR. JP 10161287A2 describes the use of a ballasted benzotriazole derivative attached to a transferable dye precursor in a low silver photographic material for use in an amplified development process. US 4,861,701 and FR 2005298 disclose the use of partially ballasted mercaptotetrazoles as inhibitor fragments as part of a DIR. JP 62-245263 describes the use of a partially ballasted mercaptotetrazole as an inhibitor fragment as part of a hydrazide developing agent. None of the above references contain inhibitor fragments that are of sufficient ClogP (as hereinafter defined) to increase the photographic speed.

[0007] A common problem with the addition of materials which are strongly adsorbed to silver halide (i.e. inhibitor fragments) directly to a silver halide emulsion is a loss in sensitivity to light. This loss in sensitivity can be magnified if the free inhibitor fragment is present with the silver halide for any period of time at elevated temperatures under typical manufacturing conditions. In order to minimize this undesirable interaction, the silver halide and the free inhibitor fragment are kept separate from each other until mixed just prior to coating. However, this complicates the manufacturing operation, requiring additional steps, equipment and handling and leads to increased cost and waste. It is highly desirable to have materials that can be held together in suspension with silver halide emulsions for extended periods of time, usually at least 5-10 minutes or more, without causing any changes in photographic performance.

[0008] A problem to be solved is to provide a color photographic element having improved light sensitivity without significant adverse effect on granularity or ease of manufacture.

[0009] The invention provides a color photographic element comprising at least one light sensitive silver halide emulsion layer having associated therewith a coupler according to Formula I:



wherein:

COUP is an organic fragment which reacts with oxidized developer to release  $-(\text{TIME})_n - \text{HSM}$ ,  
TIME is an optional timing group or linking group which connects HSM to COUP at the site of reaction with oxidized

developer,

$n = 0, 1$  or  $2$ , and

HSM is a compound having a minimum of three heteroatoms and having a ClogP sufficient to increase the speed of said element compared to the same element without the coupler.

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**[0010]** The invention improved light sensitivity without significant adverse effect on granularity or ease of manufacture:

**[0011]** The present invention relates to a light sensitive color photographic element with at least one red sensitive silver halide emulsion layer with at least one non-diffusing cyan coupler, at least one green sensitive silver halide emulsion layer with at least one non-diffusing magenta coupler and at least one blue sensitive silver halide emulsion layer with at least one non-diffusing yellow coupler, characterized in that at least one of the light sensitive silver halide emulsion layers or a layer in reactive association with that layer contains a coupler that releases a compound with at least three heteroatoms upon reaction with oxidized developer; said compound having a ClogP for the released fragment sufficient to increase the speed of at least one of said imaging (light sensitive) layer in said element compared to the same element without the coupler. It is desired that the compound of the invention should achieve an improvement in terms of photographic speed of at least  $0.05$ , and more desirably at least  $0.10$  and even  $0.25$  stops or more without causing any increase in granularity, in addition, it is desired that the compound of the invention should be capable of being in direct contact with a silver halide emulsion for some period of time (at least  $5-10$  minutes) prior to the coating operation.

**[0012]** The coupler used the invention is according to Formula I:

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wherein:

**[0013]** COUP is an organic fragment which reacts with oxidized developer to release  $-(\text{TIME})_n - \text{HSM}$ ,  
TIME is an optional timing group or linking group which connects HSM to COUP at the site of reaction with oxidized developer and may delay the formation of free HSM,  
 $n = 0, 1$  or  $2$ , and

HSM (Heterocyclic Speed Material) is a compound having a minimum of three heteroatoms as part of its ring system and having a ClogP sufficient to increase the speed of said element compared to the same element without the coupler.

**[0013]** COUP represents any material known in the art to react with oxidized developer to release a PUG (Photographically Useful Group), which in this case is  $-(\text{TIME})_n - \text{HSM}$ . COUP may release  $-(\text{TIME})_n - \text{HSM}$  by direct chemical reaction or coupling with oxidized developer or by redox reaction. After coupling with oxidized developer, COUP may form a permanent or stable dye of any color, a permanent or stable colorless adduct that can remain in the film or wash out of the film, an unstable or fugitive dye which leaves no little or no residual color in the film or an unstable adduct which further decomposes. COUP can also be attached to a polymeric backbone. After reaction with oxidized developer by a redox reaction, COUP may form a stable or unstable species or may wash out of the film.

**[0014]** TIME is an optional timing or linking which temporarily connects HSM to the active site of COUP. After reaction with oxidized developer,  $-(\text{TIME})_n - \text{HSM}$  is released from the coupler and if  $n$  is  $1$  or  $2$ , then decomposes to release free HSM. This decomposition may be fast (less than  $30$  seconds) or slow (greater than  $30$  sec), although it is generally preferred to release free HSM as fast as possible. Any of the known timing groups or temporary linking groups known in the art are suitable for this invention and particular examples and references as applied to inhibitor releasers are shown hereinafter.

**[0015]** The compounds of the invention or HSMs are structural analogs of compounds known to cause inhibition of silver development, but because of their increased hydrophobicity (as measured by ClogP) do not cause inhibition of silver development per se. Among the classes of compounds that contain a minimum of three heteroatoms and are known to cause inhibition of silver development (see references in the background of the invention) and can be included in the invention when appropriately substituted are: triazoles, oxadiazoles, thiadiazoles, oxathiazoles, thiatriazoles, benzotriazoles, tetrazoles, mercaptotetrazoles, selenotetrazoles, mercaptothiadiazoles, mercaptotriazoles, mercaptooxadiazoles, telletotetrazoles, benzisodiazoles, thioureas, purines and other polyazaindenes. It is critical for the purpose of the invention, namely an increase in photographic speed, that the overall hydrophobicity (as measured by ClogP) of the HSM is high enough to avoid inhibition of silver development. Each different class of compound useful in this invention has its own particular minimum ClogP required in order to avoid inhibition. In addition, the HSM when attached to TIME or COUP is not capable of directly adsorbing to or interacting with silver halide. The object of the invention is realized only when free HSM is released through reaction of COUP with Dox and fragmentation of the bond between HSM and TIME (if present).

[0016] The term "heteroatom" as used herein as relates to the HSM encompasses any atom other than carbon or hydrogen and includes, for example, nitrogen, sulfur, phosphorous and oxygen. When the HSM is a heterocycle, it refers only to those atoms which form an integral part of the ring system and not those that are located externally to the ring system or separated from it by at least one single, unconjugated bond or are part of an additional substituent of the ring system.

[0017] Even though the HSM fragments of the invention are not inhibitors of silver development, they are generally in a class whose lower ClogP members are inhibitors of silver development. Any of the following tests could be used on lower ClogP compounds to identify if any particular class of compound is of a type within the present invention, even though the compound itself, having a larger ClogP, is not an inhibitor of silver development.

[0018] Two different tests of potential inhibiting activity are described in Photogr. Sci and Eng, 5,283 (1961) and in Photogr. Sci and Eng, 18, 383 (1974). Another test is based on binding to silver ions, which is crucial for inhibition of silver development. Silver chloride is a useful material for emulsion-based photography, the strength of the binding of chloride to silver ions defines a lower limit of binding strength for active materials. Accordingly, the following test defines those classes of molecules that bind to silver ions that are covered under the invention described herein provided they are modified to have the desired minimum ClogP. First, to test a class, an example that is soluble at pH 10 in a carbonate buffer was chosen and a 50 ml solution that is 0.00100 M in the compound, 0.0200 M in potassium bicarbonate, and 0.0267 M in potassium carbonate was prepared and the pH is adjusted to 10.0 with either 1 M nitric acid or sodium hydroxide. With magnetic stirring, and at a temperature between 20 and 25 °C and under nitrogen, there was added 1 ml of 0.000500 M silver nitrate. Using any valid electrochemical method for measuring silver ion concentrations, the free silver ion molarity 15 min after addition was determined. The entire process was repeated at the same temperature and under other conditions with 0.00100 M sodium chloride in place of the test compound. Any substance that lowers the silver ion molarity more than does 0.00100 chloride is an active class in the invention described herein.

[0019] It is preferred that the HSM fragments in the coupler used the invention are heterocycles. One suitable class of heterocycles are polycyclic nitrogen heterocycles such as those that contain at least two ring systems composed only of carbon and at least three nitrogen atoms. Specific examples of preferred polycyclic nitrogen heterocycles with at least three nitrogen atoms as part of the ring system are benzotriazoles and tetraazaindenes (including purines). Another suitable class of heterocycles of the invention are monocyclic heterocycles comprising carbon and at least two nitrogen atoms with at most only one ring sulfur or ring oxygen atom. Specific classes of monocyclic heterocycles are triazoles, oxadiazoles, thiadiazoles and tetrazoles.

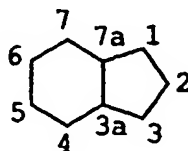
[0020] The substituents located directly on the HSMs of the invention can be hydrogen or any group chosen such that together the entire compound meets the overall ClogP requirement. These substituents may be alkyl, aryl, alkoxy or aryloxy, alkylthio or arylthio, sulfoxyl, sulfonyl, sulfamoyl ( $-\text{SO}_2\text{N}$ ), halo such as fluoro, chloro, bromo or iodo, cyano, thiol, hydroxy, nitro,  $-\text{O}-\text{CO}-$ ,  $-\text{O}-\text{SO}_2-$ , a heterocyclic group such as furanyl or morpholino, a carbonyl group such as keto, carboxylic acid ( $-\text{CO}_2\text{H}$ ), carboxylate ester ( $-\text{CO}_2-$ ) or carbamoyl ( $-\text{CON}$ ) or an amino group such as a primary, secondary or tertiary substituted nitrogen, carbonamido ( $>\text{NCO}-$ ) or sulfonamido ( $>\text{NSO}_2-$ ). In addition, the substituent may further contain a group that can be incorporated into a polymeric backbone so long as the monomeric species meets the ClogP limitations. It should be noted wherever it is possible to write alternative isomeric structures of the heterocyclic nucleus attached to TIME or COUP through alternative heteroatoms, these are considered to be part of the invention.

[0021] More preferred forms of the polycyclic nitrogen heterocycle HSMs of the invention contain a 6/6 or 6/5 two-ring bicyclic nucleus in which the two rings contain at least 4 nitrogen atoms over both ring systems so long as no three nitrogen atoms are consecutive, that is, directly connected to each other, unless one of the three consecutive nitrogens occupies a bridgehead position or all three nitrogens are located in the same six membered ring. Any particular nitrogen atom may be part of only one ring or be located in a bridgehead position. A bridgehead position is where an atom forms part of more than one ring. In addition, it is possible that other ring systems may be annulated to these heterocyclic ring systems or even be located between these rings so long as two rings (at least one of which must be a six membered ring) contain, between them, at least 4 nitrogen atoms and do not contain 3 nitrogen atoms directly connected to each other unless one of the three nitrogens occupies a bridgehead position or all three nitrogens are located in the same six membered ring. The additional rings may or may not contain additional nitrogen atoms or other heteroatoms such as sulfur or oxygen. None of the rings that comprise the heterocyclic nucleus are isolated or joined only by a single bond. It is preferred that the heterocyclic nucleus be aromatic or pseudo-aromatic. Another preferred form of polycyclic nitrogen heterocycle is benzotriazole, which contains only 3 nitrogen atoms, that are connected to each other and none of which occupies a bridgehead position.

[0022] A particularly preferred form of the HSM is a 6/5 bicyclic aromatic nitrogen heterocycle that contains at least 4 nitrogen atoms as part of the ring system and does not contain 3 nitrogen atoms directly connected to each other unless one of the three nitrogen atoms occupies a bridgehead position or all three nitrogen atoms are located in the same six membered ring and is substituted so that the overall ClogP for the compound is at least 6.2. It is preferred that the ClogP should be at least 6.8 or suitably at least 7.2. It is also preferred that the ClogP be equal to or less than 13.0,

conveniently less than 11.5.

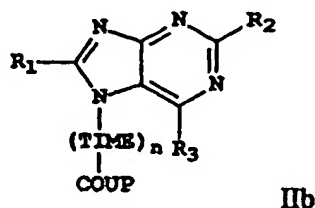
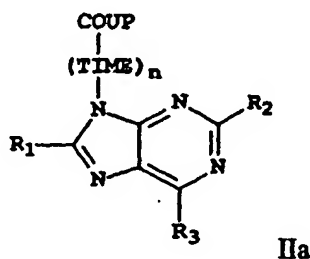
[0023] Some examples of the 6/5 bicyclic heterocycle HSMs are the following tetraazaindenes and pentaazaindenes (numbered according to the structure below): 1,3,4,6 and 1,3,5,7 (both also known as purines); 1,3,5,6; 1,3,5,7; 1,2,3a,4; 1,2,3a,5; 1,2,3a,6; 1,2,3a,7; 1,3,3a,7; 1,2,4,6; 1,2,4,7; 1,2,5,6 and 1,2,5,7. These compounds may also be described as derivatives of imidazo, pyrazolo- or triazolo-pyrimidines, pyridazines or pyrazines. Some examples of pentaazaindenes are 1,2,3a,4,7; 1,2,3a,5,7 and 1,3,3a,5,7. An example of a hexaazaindene would be 1,2,3a,4,6,7.



The more preferred examples are in which the 6/5 bicyclic nitrogen heterocycle are 1,3,4,6; 1,2,5,7; 1,2,4,6; 1,2,3a,7 or 1,3,3a,7-tetraazaindene derivatives.

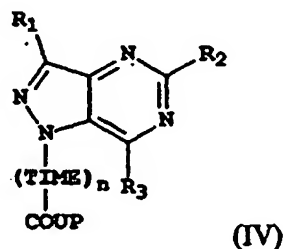
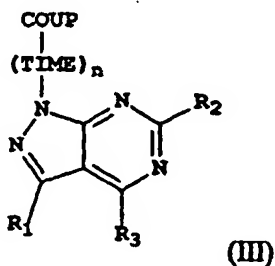
[0024] For these types of polycyclic nitrogen heterocycles, ionizable substituents, such as hydroxy (-OH), thiol (-SH) or non-tertiary amino groups (-NH<sub>2</sub> or -NH-) can be attached to a ring atom such that conjugation to a ring nitrogen can occur. It is preferred to have none of this kind of substituent, unless there is a bridgehead nitrogen in which case it is preferred to have at most only one hydroxy or thiol group and through which the HSM is attached to TIME or COUP.

[0025] The most preferred examples of the coupler used in the invention where HSM is a purine derivative are according to Formula IIa or IIb, which are isomers of each other:



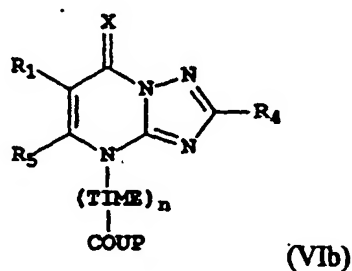
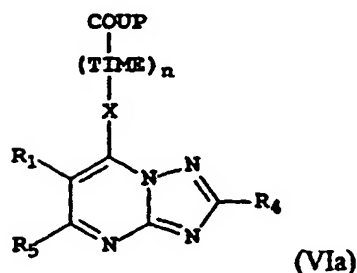
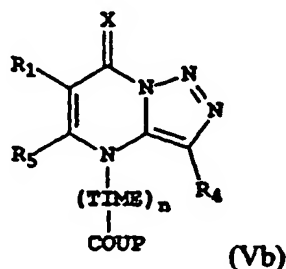
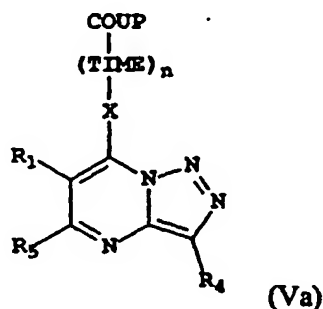
wherein R<sub>1</sub> and R<sub>2</sub> are each independently hydrogen or an alkyl, aryl, alkoxy or aryloxy, alkylthio or arylthio, sulfoxyl, sulfonyl, sulfamoyl, halo such as fluoro, chloro, bromo, and iodo, cyano, nitro, -O-CO-, -O-SO<sub>2</sub>-, a heterocyclic group, a carbonyl group such as keto, carboxylic acid, carboxylate ester or carbamoyl or an amino group such as a primary, secondary or tertiary substituted nitrogen, carbonamido or sulfonamido. R<sub>3</sub> is an alkyl, aryl, alkoxy, aryloxy, alkylthio, arylthio, sulfonyl, sulfoxyl, secondary or tertiary amino group, carbonamido group or a sulfonamido group all of which may be substituted as provided hereinafter. Compounds in which R<sub>3</sub> is an alkoxy or alkylthio group are especially preferred. The overall ClogP of the purine fragment (where TIME is replaced by a hydrogen) should be at least 6.2, or more preferably, at least 6.8 or most preferably, at least 7.2 with a maximum ClogP equal to or less than 13.0.

[0026] The most preferred examples of a coupler used in the invention where HSM is a 1,2,5,7-tetraazaindene derivative are according to Formula III or a 1,2,4,6-tetraazaindene derivative are according to Formula IV:



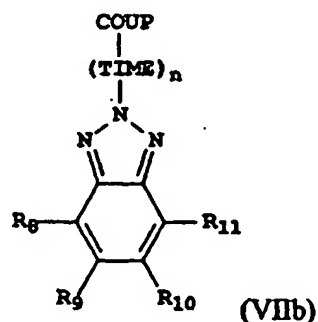
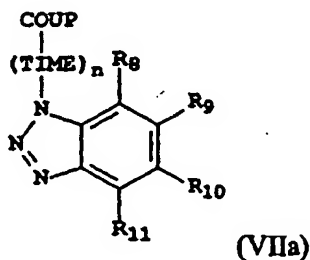
wherein  $R_1$ ,  $R_2$  and  $R_3$  are each defined above. Compounds in which  $R_3$  is an alkoxy or alkylthio group are especially preferred. The overall ClogP of the tetraazaindene fragment should be at least 6.2, or more preferably, at least 6.8 or most preferably, at least 7.2 with a maximum ClogP equal to or less than 13.0.

[0027] The most preferred examples of a coupler used in the invention where HSM is a 1,2,3a,7-tetraazaindene derivative are according to Formula Va or Vb or a 1,3,3a,7-tetraazaindene derivative according to Formula VIa or VIb:



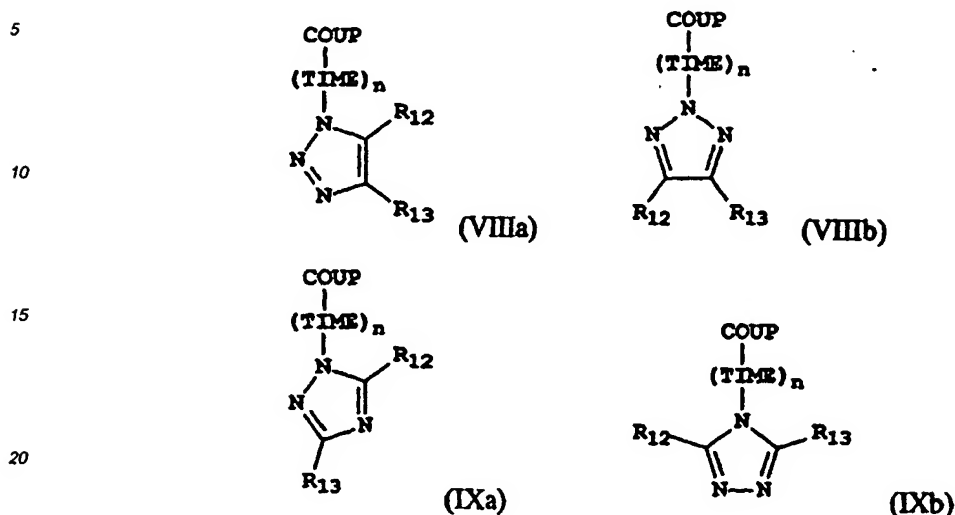
where X is oxygen or sulfur and  $R_1$  is as defined above, and  $R_4$  and  $R_5$  are independently hydrogen or an alkyl, phenyl, alkyloxy, aryloxy, alkylthio, arylthio, sulfoxide, sulfone, sulfamoyl, halo, cyano, nitro group, an -O-CO- group, an -O-SO<sub>2</sub>- group, a heterocyclic group, a carbonyl group or an amino group. Especially preferred are compounds where  $R_5$  is an alkyl group and  $R_4$  is an alkyl, aryl, alkoxy, arylthio, or alkylthio groups. The overall ClogP of the tetraazaindene fragment should be at least 6.2, or more preferably, at least 6.8 or most preferably, at least 7.2 with a maximum ClogP equal to or less than 13.0.

[0028] Mother preferred form of the coupler used in the invention is where the HSM is a benzotriazole according to Formula VIIa or VIIb:



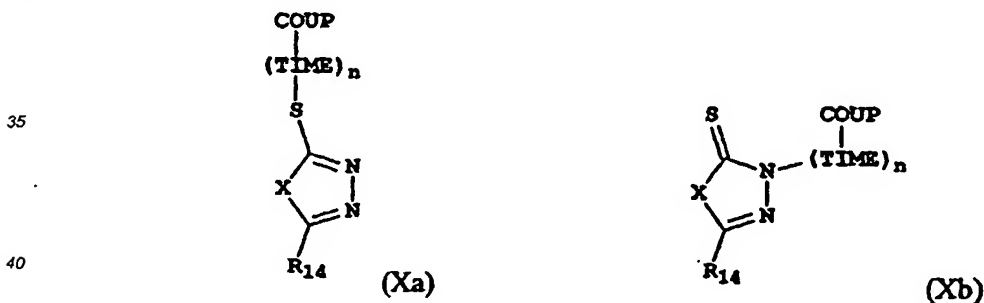
wherein  $R_8$ ,  $R_9$ ,  $R_{10}$  and  $R_{11}$  are each individually defined as for  $R_1$  and  $R_2$  above. The overall ClogP for the benzotriazole fragment is at least 7.8, or more preferably at least 8.2 or most preferably at least 9.0. It is also preferred that the ClogP be equal to or less than 13.0. The most preferred examples of a benzotriazole derivative are where  $R_8$  and  $R_{11}$  are hydrogen and where  $R_9$  is a carboxylate ester, a carbamoyl group, a carbonamido group, a sulfonamido group or an alkoxy or aryloxy group.

[0029] Another preferred form of the coupler used in the invention is where HSM is a 1,2,3-triazole according to Formula VIIIa or VIIIb or a 1,2,4-triazole according to Formula IXa or IXb:



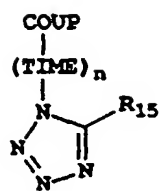
25 wherein  $R_{12}$  and  $R_{13}$  are each individually defined as for  $R_1$  and  $R_2$  above. The overall ClogP for the triazole fragments is at least 8.75, or more preferably at least 9.0 or most preferably at least 9.25 and equal to or less than 13.0. The most preferred examples of triazole fragments are where  $R_{12}$  is hydrogen, alkyl or aryl and  $R_{13}$  is an alkylthio or arylthio, carboxylate ester or substituted alkyl group.

[0030] Another preferred form of the coupler used in the invention is where HSM is a diazole according to Formula Xa or Xb:

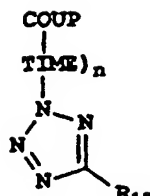


45 wherein X is oxygen or sulfur and  $R_{14}$  is the same as  $R_1$  above. The ClogP for the diazole fragment is at least 7.6, or more preferably at least 7.9 or most preferably at least 8.2 and equal to or less than 11.5. The most preferred examples of an oxadiazole or a thiadiazole are where  $R_{14}$  is an alkyl, aryl, alkylthio, arylthio, heterocyclic or amino group.

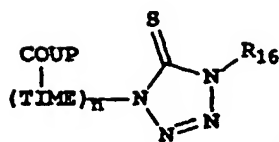
[0031] Another preferred form of the coupler used in the invention is where HSM is a tetrazole. If the tetrazole is not substituted with a thiol group, then it is connected to TIME or COUP through a ring nitrogen according to Formula XIa or XIb. If the tetrazole contains a thiol substituent (a mercaptotetrazole), then it may be connected through either the ring nitrogen as in Formula XIIa or through the exocyclic sulfur as in Formula XIIb:



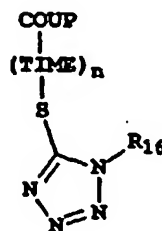
(XIa)



(XIb)



(XIIa)



(XIIb)

wherein  $R_{15}$  is an alkyl, aryl, heterocyclic, alkylthio, arylthio, alkyloxy, aryloxy, amino, sulfonyl, sulfoxyl or carbonyl group and  $R_{16}$  is an alkyl, aryl or heterocyclic group. The most preferred examples of a tetrazole are when  $R_{15}$  is an alkyl, aryl or heterocyclic group. For the HSM shown in Formulas XIIa or XIIb (mercaptotetrazole), the ClogP for the compound should be at least 7.0 or more preferably at least 7.4 or most preferably at least 7.8 and preferably the ClogP should be equal or less than 13.0. For the HSM shown in Formula XIa or XIb, the ClogP for the compound should be at least 6.5 or more preferably at least 7.0 or most preferably at least 7.5 and should be less than or equal to 10.5.

[0032] An important feature of the invention is the hydrophobicity (which is related to their octanol/water partition coefficient (logP)) of the released HSM fragment. The overall ClogP of the coupler of Formula I is not critical. In order to maximize the photographic effect, the partitioning into water of the HSM cannot be so low that the released HSM is unable to reach the surface of the emulsion grains. It has also been found that the partitioning of the released HSM into water cannot be too high. Because it can be difficult to measure logP values above 3, a model can be used to compute an estimate of logP, called ClogP that defines the limits of the invention. The model used is MEDCHEM Version 3.54, which is a software program produced by the Medicinal Chemistry Project at Pomona College in California. One way to enter the structure of the HSM fragment (where hydrogen replaces the bond to TIME or COUP) into the MEDCHEM program in order to calculate a ClogP is through a SMILES string. The way to enter the SMILES string for a nitrogen compound is to enter all non-hydrogen atoms as capitals and let the MEDCHEM program determine the appropriate aromaticity. An example is shown for a purine below: CCCCCCCCCCCCCOC1=C2N=CNC2=NC=N1. This entry gives the value 6.91. When the entry is in this form, the heterocyclic N-H will be drawn in the structure by the MEDCHEM program. If the entry is not in this form, the MEDCHEM program will not display the heterocyclic N-H group and the resulting ClogP value is incorrect. Structures such as purines and other heterocycles can be drawn in multiple tautomeric forms, for example, hydrogens on different ring atoms, enol or keto tautomeric forms (or thiol or thione forms for sulfur compounds). If ClogP values can be calculated for more than one tautomeric form of a single compound and at least one of those values is within the specified range for that class, then the compound is within the scope of the invention. Some tautomers may not compute in MEDCHEM 3.54, because there is a fragment in the molecule that is missing in the MEDCHEM database. In such a case, logP of the nucleus of the molecule (with appropriate aromatic or aliphatic substituents) must be experimentally measured and the missing fragment value must be entered into the algorithm manager of MEDCHEM as instructed by the manual.

[0033] For the purposes of this invention, the ClogP refers to neutral molecules, even if they would be ionized or protonated (either fully or in part) at the processing pH or at the ambient pH of the photographic film. Thus, in practice, it is highly desirable that the substituents of the HSM part of the invention do not contain additional very low  $pK_a$  ( $<7$ ) groups such as sulfonic or carboxylic acids nor very basic groups ( $pK_a$  of conjugate acid  $<10$ ) such as a tertiary amino group (unless such an amino group is attached to a heterocyclic ring such that it is conjugated to a nitrogen atom, in which case its basicity is greatly reduced) since they require an increase in the size and amount in the rest of the hydrophobic substituents in order to meet the overall ClogP requirements of the HSM fragment.

[0034] There is a specific range of ClogP for each class of HSM fragments, depending on its particular nature, which should not be exceeded. For most examples, it is preferred that the ClogP not exceed 13.0 or more preferably for some types of compounds, not to exceed 11.5. When the compound has a ClogP equal to or greater than some mini-



num value to show the desired speed effect silver inhibition does not occur. For most examples, the ClogP should not be lower than 6.2 and it is preferred that the ClogP of the compound be at least 6.8 or greater or even 7.2 or greater.

5 [0035] One of the most important and novel characteristics of the HSM compounds used in this invention is the finely tuned balance between their hydrophobic and hydrophilic nature. The hydrophobic/hydrophilic nature of a compound can be estimated by calculation of its partition coefficient between octanol and water (ClogP) using the MED-CHEM program, and this has been used herein to define the range of values of ClogP for each class of compound within which they exhibit the desired effect. The terms 'ballast' or 'ballasted' as generally applied in the photographic art are often applied only loosely and without quantification to imply a restriction of movement. The activity of the HSM compounds is therefore best defined in terms of their calculated ClogP values for the HSM compound itself. The overall  
10 ClogP of the coupler containing the HSM fragment is not important in terms of providing increased speed.

[0036] For each coupler used in the invention, as the laydown is increased a threshold level is reached following which the speed improvement gradually increases with laydown, after which the improvement then levels off at a compound specific maximum level. It will be appreciated that the amount is also a function of other variables such as the location and number of layers in which the compound is located, the solvent used, and film dimensions. Thus, it is desirable  
15 to have enough laydown of the compound obtain the speed improvement. Suitably, there is present sufficient laydown to achieve an improvement of 0.05, and desirably 0.10 and more desirably 0.25 stops. Where the compound is present in a sensitized layer, the ratio of compound to silver is suitably at least 0.1 mmol of compound per mol of silver halide and, more preferably, at least 1.0 mmol of compound per mol of silver halide and, most preferably, at least 2.0 mmol per mol of silver halide.

20 [0037] The following are examples of inventive couplers, along with the corresponding ClogP values of the free HSM fragment (where a hydrogen replaces TIME or COUP) that are useful in this invention:

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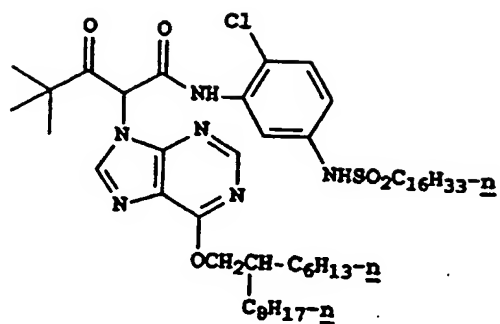
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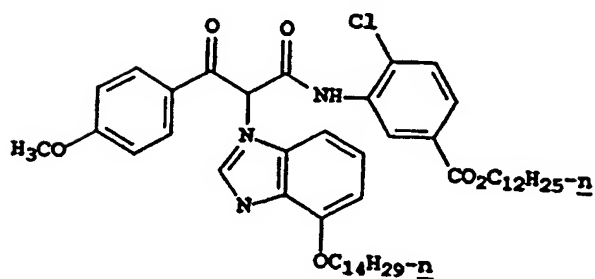
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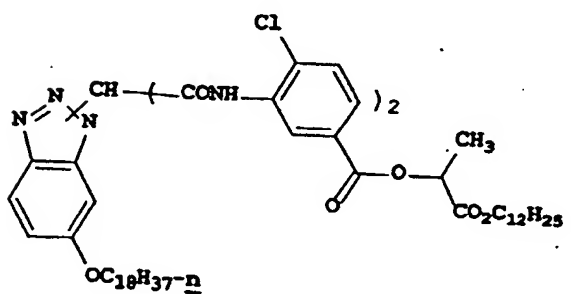
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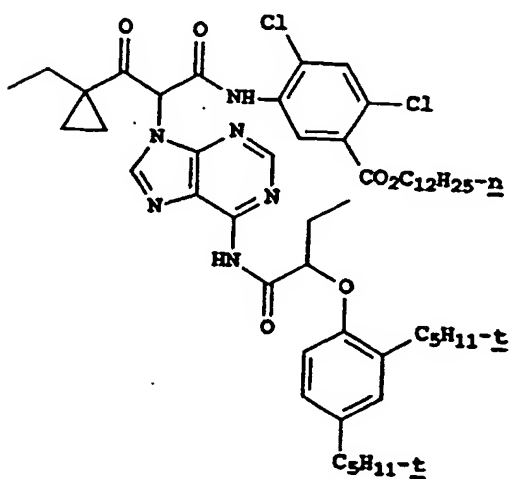
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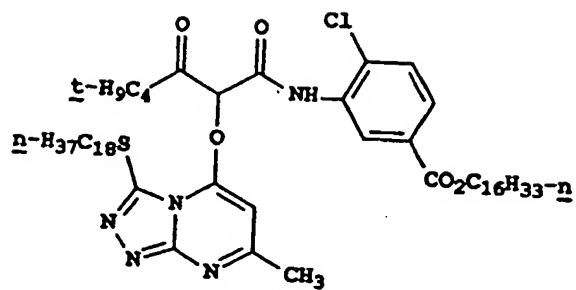
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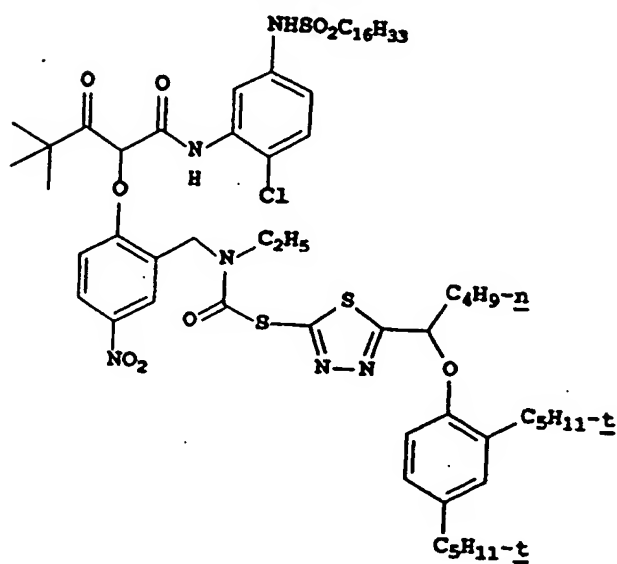
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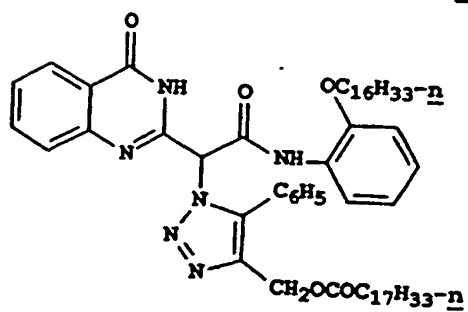
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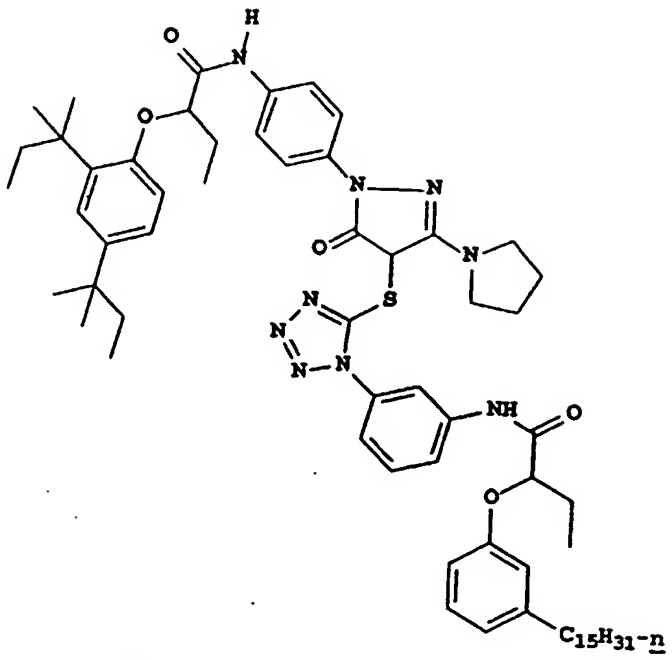
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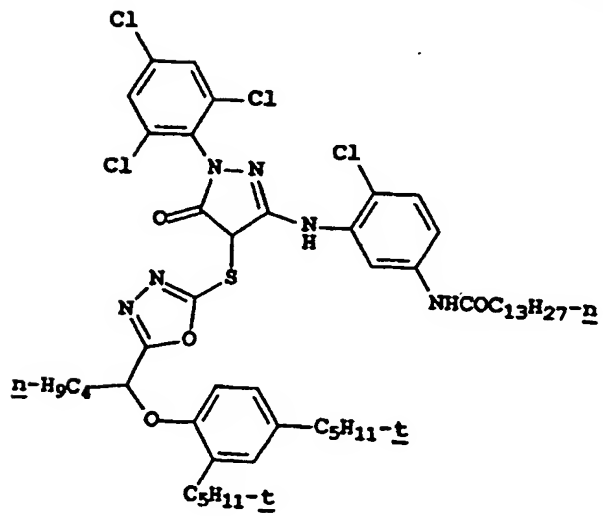
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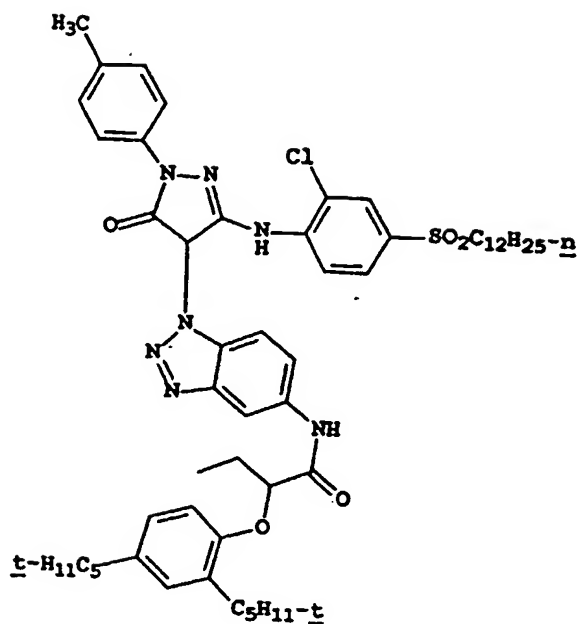
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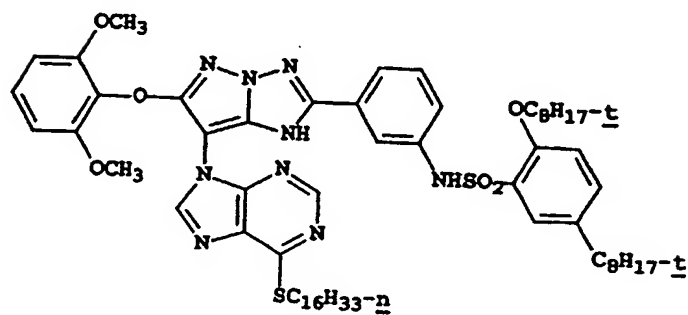
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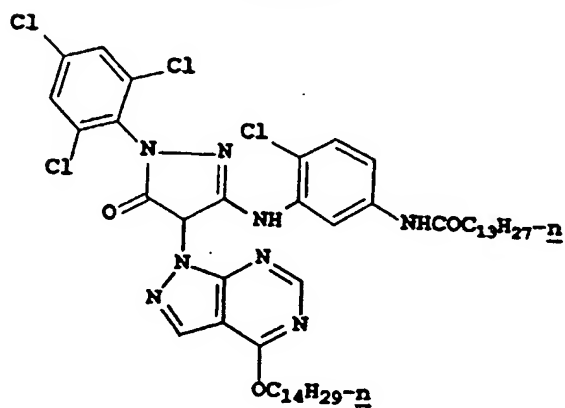
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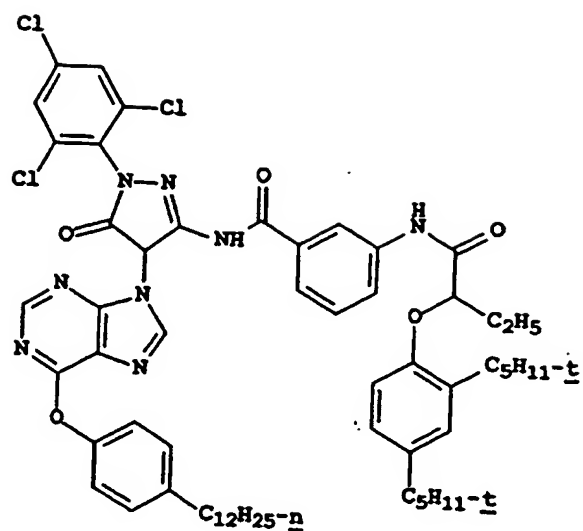
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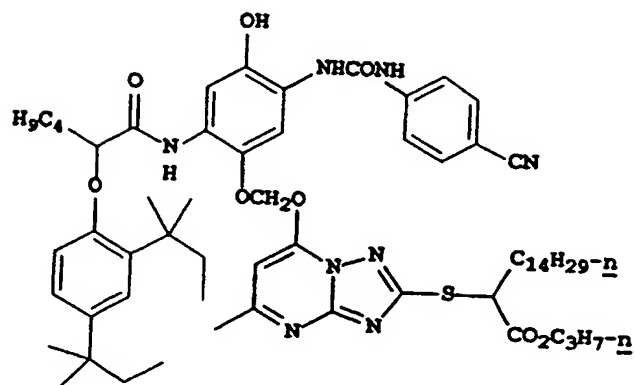
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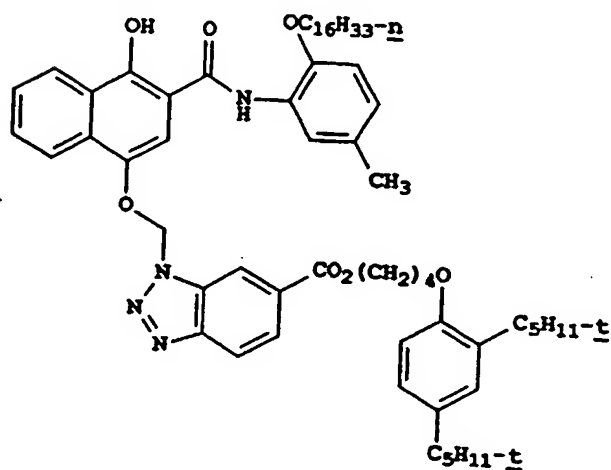
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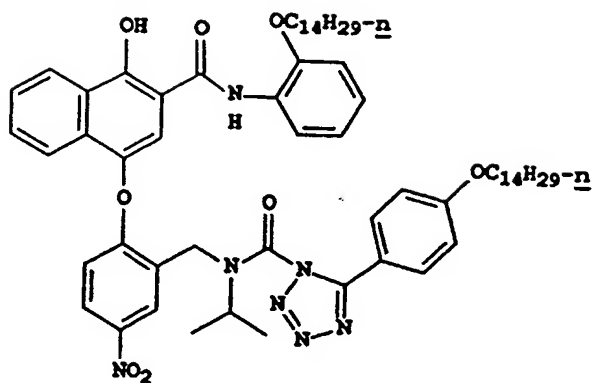
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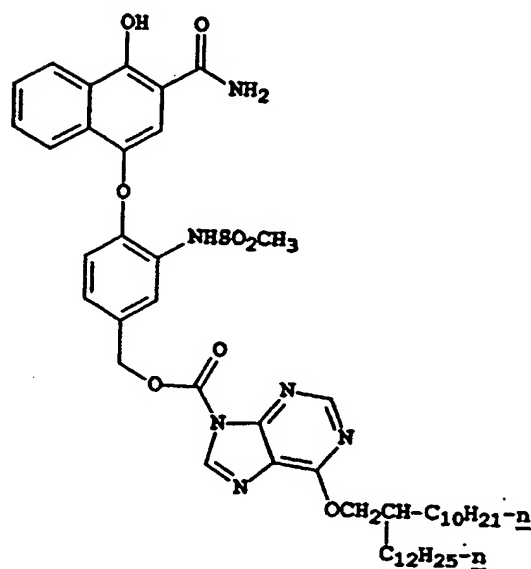
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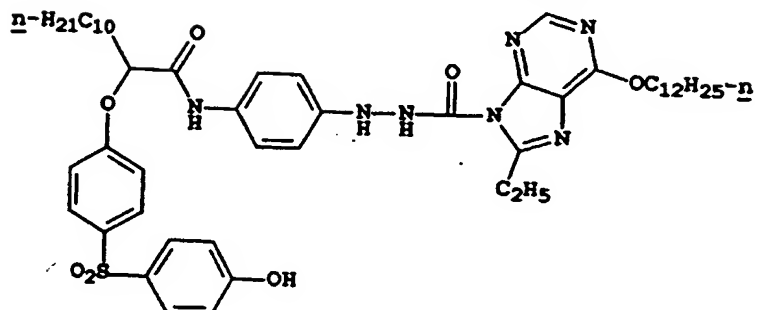
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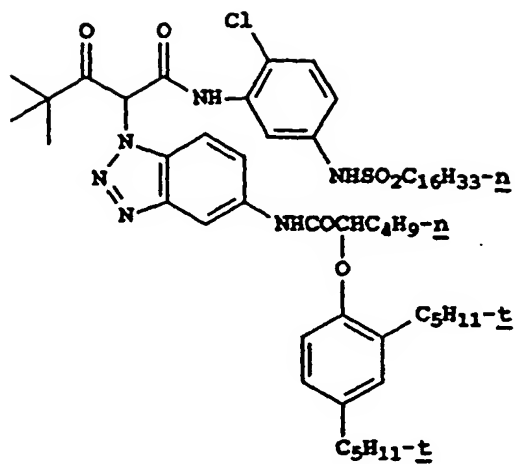
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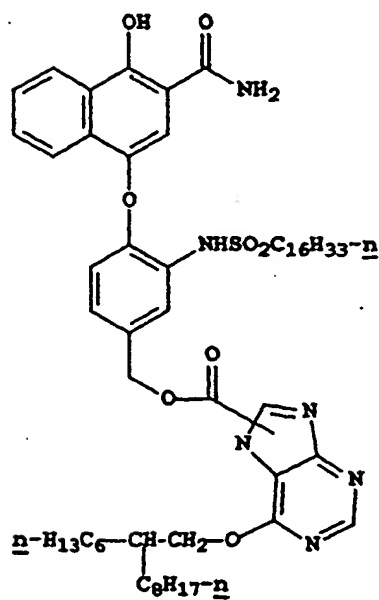
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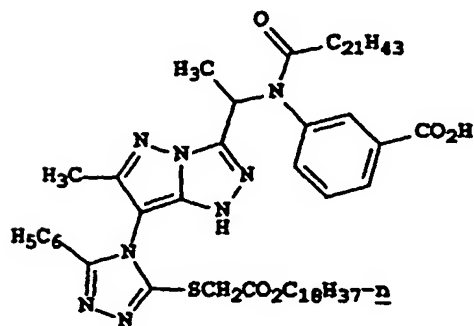
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(9.04)



T:  
(7.84)

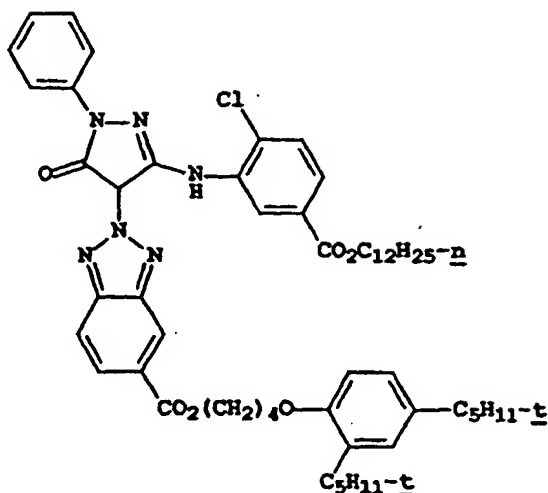


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(10.23)





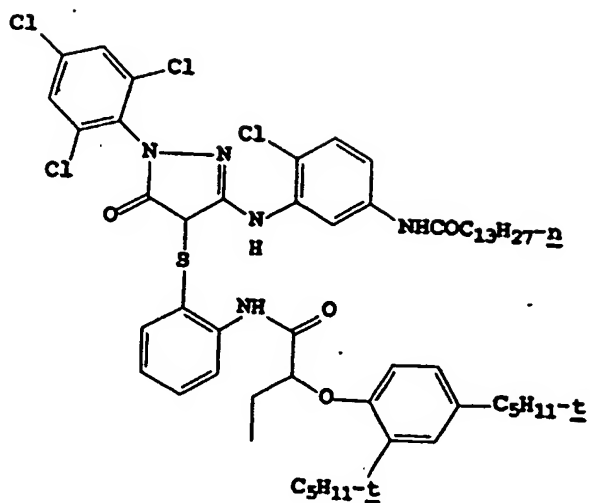
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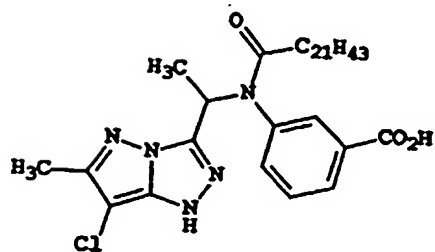
[0038] The materials of the invention can be added to a mixture containing silver halide before coating or be mixed with the silver halide just prior to or during coating. In either case, additional components like couplers, doctors, surfactants, hardeners and other materials that are typically present in such solutions may also be present at the same time. The materials of the invention are not water-soluble and cannot be added directly to the solution. They may be added directly if dissolved in an organic water miscible solution such as methanol, acetone or the like or more preferably as a dispersion. A dispersion incorporates the material in a stable, finely divided state in a hydrophobic organic solvent (often referred to as a coupler solvent or permanent solvent) that is stabilized by suitable surfactants and surface active agents usually in combination with a binder or matrix such as gelatin. The dispersion may contain one or more permanent solvents that dissolve the material and maintain it in a liquid state. Some examples of suitable permanent solvents are tricresylphosphate, N,N-diethylauramide, N,N-dibutylauramide, p-dodecylphenol, dibutylphthalate, di-n-butyl sebacate, N-n-butylacetanilide, 9-octadecen-1-ol, *ortho*-methylphenyl benzoate, trioctylamine and 2-ethylhexylphosphate. Permanent solvents can also be described in terms of physical constants such as *alpha*, *beta* and *pi*<sup>\*</sup> as defined by M.J. Kamlet, J.-L.M. Abboud, M.H. Abraham and R.W. Taft, J. Org Chem, 48, 2877(1983). The preferred permanent solvents used with the materials of the invention are those with ClogP of 5.0 or greater and *beta* values of 0.4 or greater or more preferably, *beta* values of 0.5 or greater. Preferred classes of solvents are carbonamides, phosphates, alcohols and esters. When a solvent is present, it is preferred that the weight ratio of compound to solvent be at least 1 to 0.5, or most preferably, at least 1 to 1. The dispersion may require an auxiliary coupler solvent initially to dissolve the component but this is removed afterwards, usually either by evaporation or by washing with additional water. Some examples of suitable auxiliary coupler solvents are ethyl acetate, cyclohexanone and 2-(2-butoxyethoxy)ethyl acetate. The dispersion may also be stabilized by addition of polymeric materials to form stable latexes. Examples of suitable polymers for this use generally contain water-solubilizing groups or have regions of high hydrophilicity. Some examples of suitable dispersing agents or surfactants are Alkanol XC or saponin. The materials of the invention may also be dispersed as an admixture with another component of the system such as a coupler or an oxidized developer scavenger so that both are present in the same oil droplet. It is also possible to incorporate the materials of the invention as a solid particle dispersion; that is, a slurry or suspension of finely ground (through mechanical means) compound. These solid particle dispersions may be additionally stabilized with surfactants and/or polymeric materials as known in the art. Also, additional permanent solvent may be added to the solid particle dispersion to help increase activity.

[0039] The sensitivity of the human eye is greatest to green light and so, the compounds of the invention are most useful when located in the green record (the layer whose maximum spectral sensitivity to light falls between 500 and 600 nm). The following magenta couplers are particularly beneficial when used in conjunction with the couplers used in the invention:

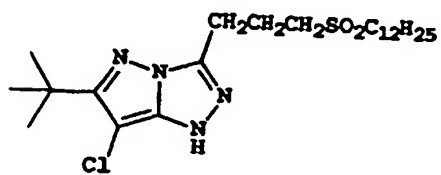
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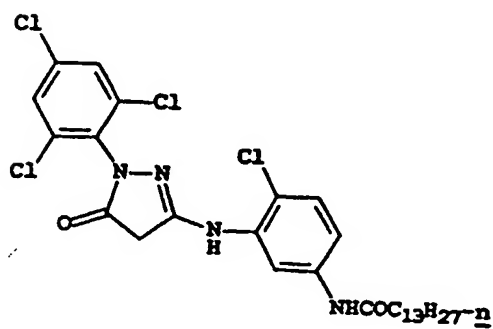
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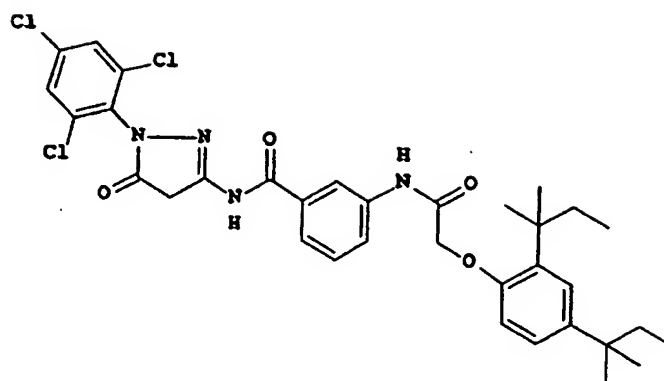
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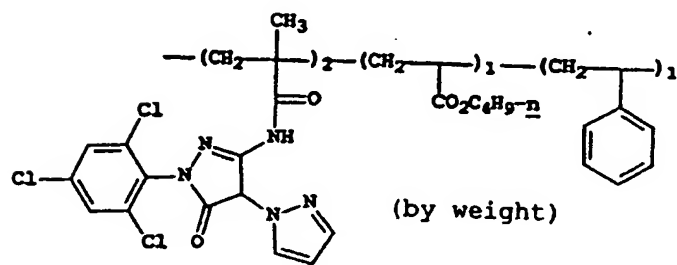
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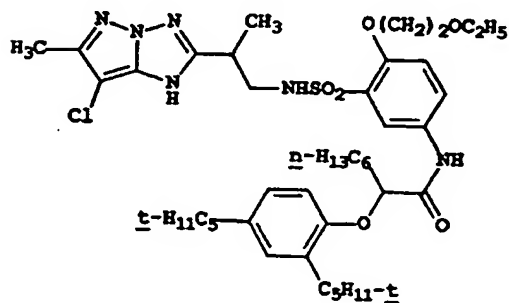
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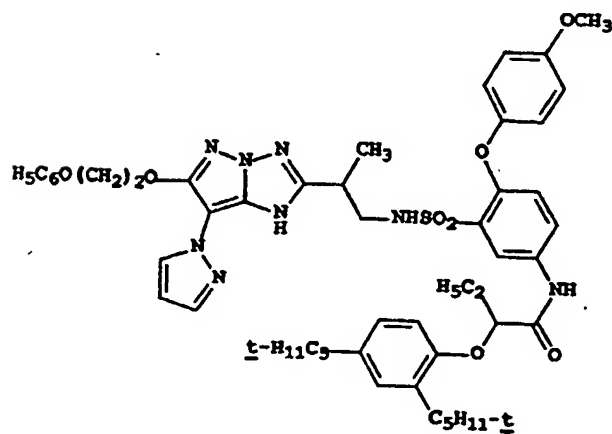
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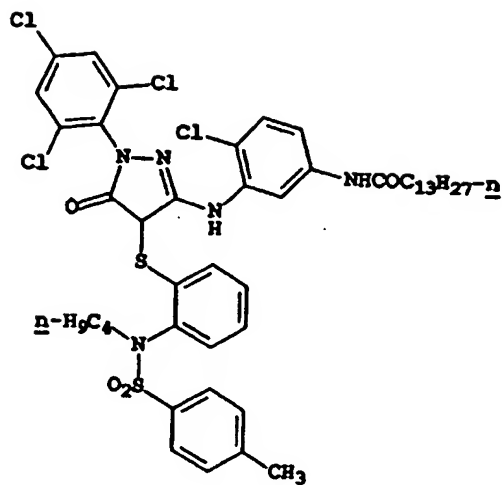
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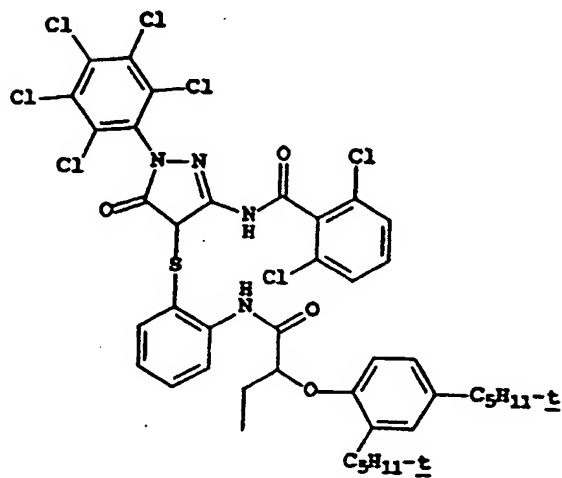
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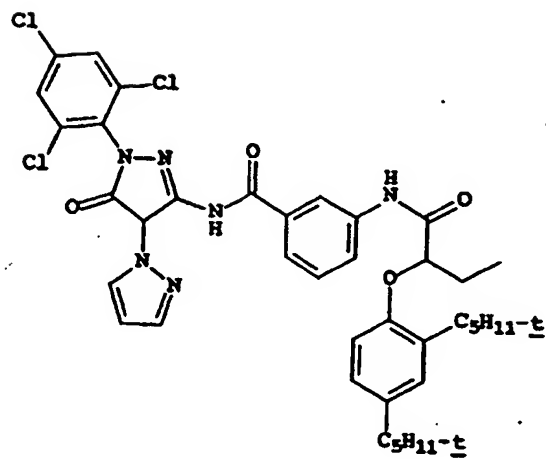
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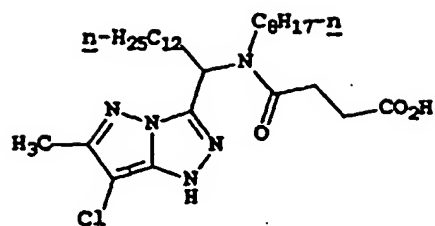
M-10:



M-11:

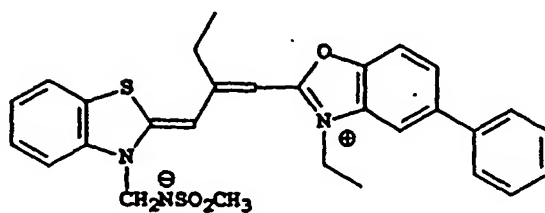


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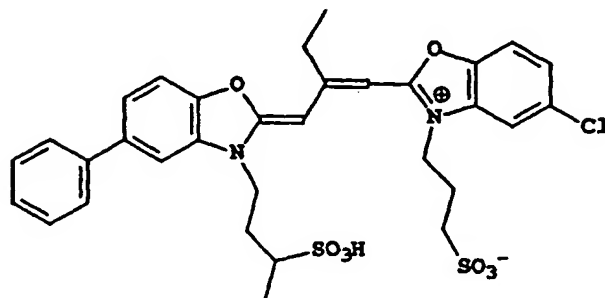


[0040] The following green sensitizing dyes are also particularly beneficial when used in combination with the couplers used in the invention:

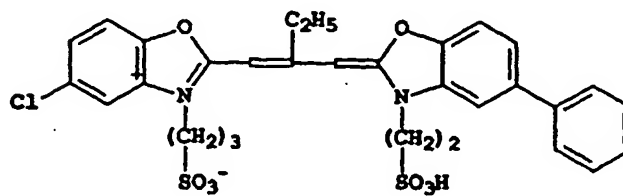
GSD-1



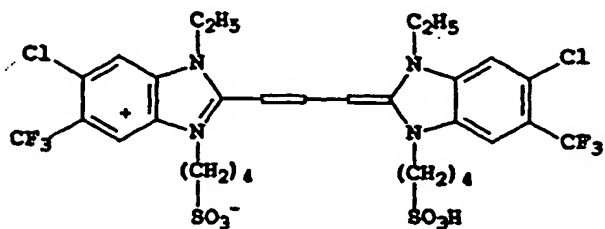
GSD-2

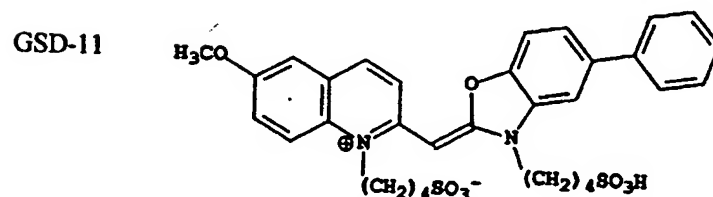
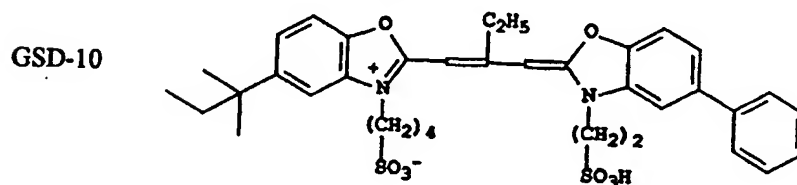
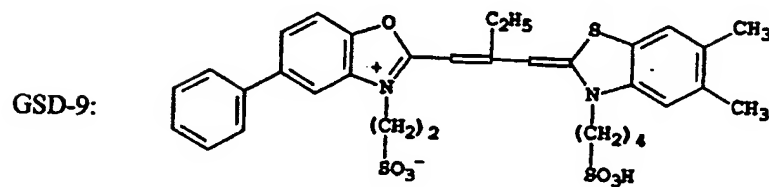
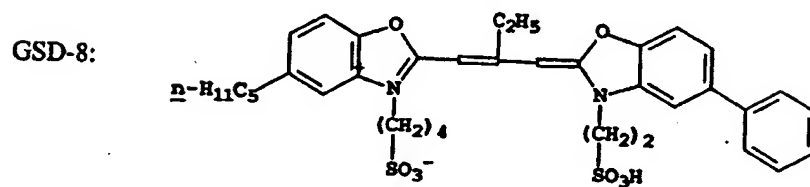
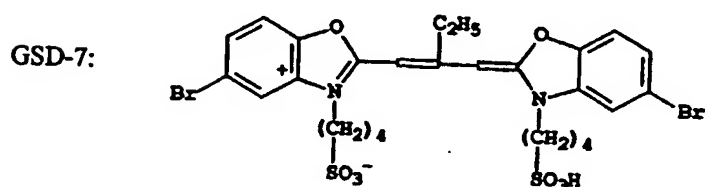
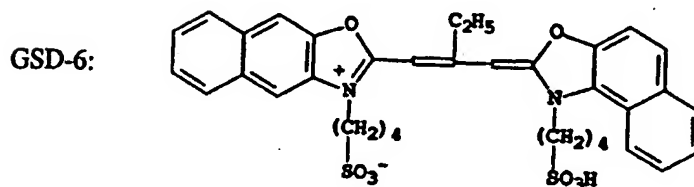
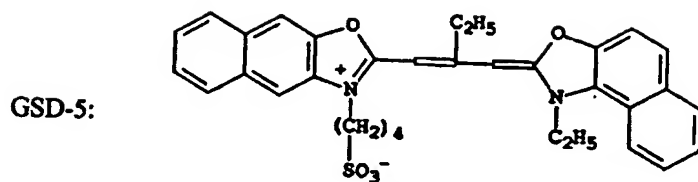


GSD-3:



GSD-4:





[0041] The type of light sensitive silver halide emulsion used in the layer that contains the compound useful in the invention may be important to obtain the desired increase in light sensitivity. The silver halide emulsion is suitably a silver iodobromide emulsion, meaning an emulsion that is low in chloride. By low in chloride, it is meant that there should

be no more than 20 mol %. More suitably, there is present in the layer no more than 10 mol % chloride, and typically no more than 1 mol % chloride. The emulsion suitably contains at least 0.01 mol % iodide, or more preferably, at least 0.5 mol % iodide or most preferably, at least 1 mol % iodide. The benefit of the increase in light sensitivity is most apparent in combination with larger sized emulsions that are associated with increased granularity. Thus, it is preferred that the compounds of the invention are used with emulsions that have an equivalent circular diameter of at least 0.6 micrometer, or more preferably, at least 0.8 micrometer, or most preferably, at least 1.0 micrometer. In addition, the benefit of the invention is greatest in origination materials such as color negative or color reversal materials since they require higher sensitivity to light (because of the variable lighting conditions in natural scenes) and low granularity (due to high magnification) relative to color print materials for which exposure conditions are carefully controlled and which are viewed directly under low magnification conditions.

[0042] The compounds of the invention are also particularly useful when used in film elements that contain low overall silver levels. Thus, films containing 9 g/m<sup>2</sup> of total silver or less, or more preferably 5.4 g/m<sup>2</sup> or less or even 4.3 g/m<sup>2</sup> or less benefit from the use of the compounds of the invention.

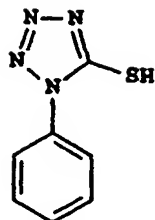
[0043] In order to control and maintain granularity over a wide exposure range, it is a common practice to divide an individual color record into separate layers, each containing silver halide emulsions of different degree of sensitivity to the same color of light. While the compound of the invention is most useful in the most light sensitive layer, it can be used in more than one record that is sensitive to the same color of light. For example, in a color record that is split into three layers of different relative sensitivity; fast (F), mid (M) or slow (S), the compound can be used in each layer only or in any combination; i.e. F+M, F+M+S or F+S. It is not necessary that these layers be adjacent; that is, they may have interlayers or even imaging layers that are sensitive to other colors located between them. In addition, although the most light sensitive layer is typically located in the film structure closest to the exposure source and farthest from the support, the compounds of the invention allow for alternative locations of the layers; for example, a more light sensitive layer containing the compound of the invention may be located below (farther from the exposing source) than a less sensitive layer. It is also possible to use the compounds of the invention in more than one color record at a time.

[0044] Moreover, when a number of layers of the same spectral sensitivity but of differing degrees of sensitivity to light are used, it is known that overall granularity can be minimized by using a smaller molar amount of dye-forming coupler than silver in the layers of higher sensitivity. Thus, it is preferred that the layers containing the compound of the invention additionally contain less than a stoichiometric amount of total dye forming coupler(s) relative to the amount of silver contained in the same layer. A suitable molar ratio of dye-forming coupler(s) to silver in the layer containing the compound of the invention would be less than 0.5. Most preferred would be a ratio of 0.2 or even 0.1 or less.

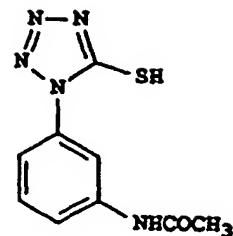
[0045] The desired effect of the invention can also be obtained when the compound of the invention is located in a non-silver halide containing layer adjacent to an imaging layer, particularly the most sensitive layer of a multilayer record, so that it is in reactive association with the imaging layer. Preferably, this layer is an interlayer located between two light sensitive imaging layers. The interlayer can be located between two imaging layers sensitive to the same color or different. It is also possible that the interlayer containing the compound is located between an imaging layer and an antihalation layer. The layer may also contain additional materials such as oxidized developer scavengers or colored organic filter dyes. It is preferred for this embodiment that the coupler be located in an interlayer between the blue and green sensitive color records or an interlayer between the green and red sensitive color records.

[0046] The compounds of the invention tend to increase the Dmin of the emulsion layer in which they are coated. Thus, it is often highly advantageous to use the compounds of the invention in combination with any of the antifoggants or scavengers known in the art to be useful in controlling Dmin or fog. Specific examples of scavengers for oxidized developers would be 2,5-di-*t*-octylhydroquinone, 2-(3,5-bis-(2-hexyl-dodecylainido)benzamido)-1,4-hydroquinone, 2,4-(4-dodecyloxybenzenesulfonamido)phenol, 2,5-dihydroxy-4-(1-methylheptadecyl)benzenesulfonic acid or 2,5-di-s-dodecylhydroquinone. Specific examples of useful antifoggants are compounds AF-1 to AF-8 whose structures are shown below as well as 4-hydroxy-6-methyl-1,3,3a,7-tetraazaindene:

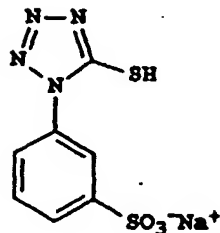
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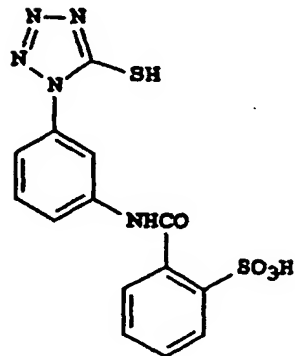
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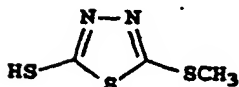
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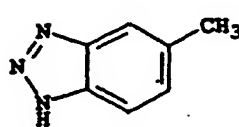
AF-4:



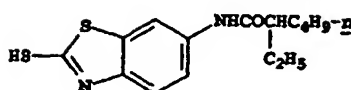
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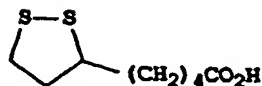
AF-6:



AF-7:



AF-8:



[0047] Unless otherwise specifically stated or when the term "group" is used, it is intended throughout this specification, when a substituent group contains a substitutable hydrogen, it is intended to encompass not only the substituent's unsubstituted form, but also its form further substituted with any group or groups as herein mentioned, so long as the group does not destroy properties necessary for photographic utility. Suitably, a substituent group may be halogen or may be bonded to the remainder of the molecule by an atom of carbon, silicon, oxygen, nitrogen, phosphorous, or sulfur. The substituent may be, for example, halogen, such as chlorine, bromine, iodine or fluorine; nitro; hydroxyl; cyano; carboxyl; or groups which may be further substituted, such as alkyl, including straight or branched chain or cyclic alkyl, such as methyl, trifluoromethyl, ethyl, *t*-butyl, 3-(2,4-di-*t*-pentylphenoxy)propyl, and tetradecyl; alkenyl, such as ethylene, 2-butene; alkoxy, such as methoxy, ethoxy, propoxy, butoxy, 2-methoxyethoxy, *sec*-butoxy, hexyloxy, 2-ethylhexyloxy, tetradecyloxy, 2-(2,4-di-*t*-pentylphenoxy)ethoxy, and 2-dodecyloxyethoxy; aryl such as phenyl, 4-*t*-butylphenyl, 2,4,6-trimethylphenyl, naphthyl; aryloxy, such as phenoxy, 2-methylphenoxy, alpha- or beta-naphthyloxy, and 4-tolyloxy; carbonamido, such as acetamido, benzamido, butyramido, tetradecanamido, alpha-(2,4-di-*t*-pentylphenoxy)acetamido, alpha-(2,4-di-*t*-pentylphenoxy)butyramido, alpha-(3-pentadecylphenoxy)hexanamido, alpha-(4-hydroxy-3-*t*-butylphenoxy)tetradecanamido, 2-oxopyrrolidin-1-yl, 2-oxo-5-tetradecylpyrrolin-1-yl, N-methyltetradecanamido, N-succinimido, N-phthalimido, 2,5-dioxo-1-oxazolidinyl, 3-dodecyl-2,5-dioxo-1-imidazolyl, and N-acetyl-N-dodecylamino, ethoxycarbonylamino, phenoxycarbonylamino, benzyloxycarbonylamino, hexadecyloxycarbonylamino, 2,4-di-*t*-butylphenoxy carbonylamino, phenyl carbonylamino, 2,5-(di-*t*-pentylphenyl) carbonylamino, *p*-dodecyl-phenyl-



carbonylamino, *p*-tolylcarbonylamino, N-methylureido, N,N-dimethylureido, N-methyl-N-dodecylureido, N-hexadecylureido, N,N-dioctadecylureido, N,N-dioctyl-N'-ethylureido, N-phenylureido, N,N-diphenylureido, N-phenyl-N-*p*-tolylureido, N-(*m*-hexadecylphenyl)ureido, N,N-(2,5-di-*t*-pentylphenyl)-N'-ethylureido, and *t*-butylcarbonamido; sulfonamido, such as methylsulfonamido, benzenesulfonamido, *p*-tolylsulfonamido, *p*-dodecylbenzenesulfonazido, N-methyl-  
 5 tetradecylsulfonamido, N,N-dipropylsulfamoylamino, and hexadecylsulfonamido; sulfamoyl, such as N-methylsulfamoyl, N-ethylsulfamoyl, N,N-dipropylsulfamoyl, N-hexadecylsulfamoyl, N,N-dimethylsulfamoyl; N-[3-(dodecyloxy)propyl]sulfamoyl, N-[4-(2,4-di-*t*-pentylphenoxy)butyl]sulfamoyl, N-methyl-N-tetradecylsulfamoyl, and N-dodecylsulfamoyl; carbamoyl, such as N-methylcarbamoyl, N,N-dibutylcarbamoyl, N-octadecylcarbamoyl, N-[4-(2,4-di-*t*-  
 10 pentylphenoxy)butyl]carbamoyl, N-methyl-N-tetradecylcarbamoyl, and N,N-dioctylcarbamoyl; acyl, such as acetyl, (2,4-di-*t*-amylphenoxy)acetyl, phenoxycarbonyl, *p*-dodecyloxyphenoxycarbonyl methoxycarbonyl, butoxycarbonyl, tetradecyloxycarbonyl, ethoxycarbonyl, benzyloxycarbonyl, 3-pentadecyloxycarbonyl, and dodecyloxycarbonyl; sulfonyl, such as methoxysulfonyl, octyloxysulfonyl, tetradecyloxysulfonyl, 2-ethylhexyloxysulfonyl, phenoxysulfonyl, 2,4-di-*t*-pentyl-  
 15 phenoxysulfonyl, methylsulfonyl, octylsulfonyl, 2-ethylhexylsulfonyl, dodecylsulfonyl, hexadecylsulfonyl, phenylsulfonyl, 4-nonylphenylsulfonyl, and *p*-tolylsulfonyl; sulfonyloxy, such as dodecylsulfonyloxy, and hexadecylsulfonyloxy; sulfinyl, such as methylsulfinyl, octylsulfinyl, 2-ethylhexylsulfinyl, dodecylsulfinyl, hexadecylsulfinyl, phenylsulfinyl, 4-nonylphenylsulfinyl, and *p*-tolylsulfinyl; thio, such as ethylthio, octylthio, benzylthio, tetradecylthio, 2-(2,4-di-*t*-pentylphenoxy)ethylthio, phenylthio, 2-butoxy-5-*t*-octylphenylthio, and *p*-tolylthio; acyloxy, such as acetyloxy, benzoyloxy, octadecanoyloxy, *p*-dodecylamidobenzoyloxy, N-phenylcarbamoyloxy, N-ethylcarbamoyloxy, and cyclohexylcarbonyloxy; amine, such as phenylanilino, 2-chloroanilino, diethylamine, dodecylamine; imino, such as 1-(N-phenylimido)ethyl, N-succinimido or 3-benzylhydantoinyl; phosphate, such as dimethylphosphate and ethylbutylphosphate; phosphite, such as diethyl and dihexylphosphite; a heterocyclic group, a heterocyclic oxy group or a heterocyclic thio group, each of which may be substituted and which contain a 3 to 7 membered heterocyclic ring composed of carbon atoms and at least one hetero atom selected from the group consisting of oxygen, nitrogen and sulfur, such as 2-furyl, 2-thienyl, 2-benzimidazolyl or 2-benzothiazolyl; quaternary ammonium, such as triethylammonium; and silyloxy, such as trimethylsilyloxy.

[0048] If desired, the substituents may themselves be further substituted one or more times with the described substituent groups. The particular substituents used may be selected by those skilled in the art to attain the desired photographic properties for a specific application and can include, for example, hydrophobic groups, solubilizing groups, blocking groups, releasing or releasable groups. Generally, the above groups and substituents thereof may include  
 30 those having up to 48 carbon atoms, typically 1 to 36 carbon atoms and usually less than 24 carbon atoms, but greater numbers are possible depending on the particular substituents selected.

[0049] To control the migration of various components, it may be desirable to include a high molecular weight or polymeric backbone containing hydrophobic or "ballast" group in molecules. Representative ballast groups include substituted or unsubstituted alkyl or aryl groups containing 8 to 48 carbon atoms. Representative substituents on such groups  
 35 include alkyl, aryl, alkoxy, aryloxy, alkylthio, hydroxy, halogen, alkoxycarbonyl, aryloxycarbonyl, carboxy, acyl, acyloxy, amino, anilino, carbonamido, carbamoyl, alkylsulfonyl, arylsulfonyl, sulfonamido, and sulfamoyl groups wherein the substituents typically contain 1 to 42 carbon atoms. Such substituents can also be further substituted.

[0050] When the term "associated" is employed, it signifies that a reactive compound is in or adjacent to a specified layer where, during processing, it is capable of reacting with other components. As used herein, the term "color photographic element" means any element containing a light-sensitive silver halide emulsion layer containing an image dye-forming coupler. They can be single color elements or multicolor elements. Multicolor elements contain image dye-forming units sensitive to each of the three primary regions of the spectrum. Each unit can comprise a single emulsion layer or multiple emulsion layers sensitive to a given region of the spectrum. The layers of the element, including the layers of the image-forming units, can be arranged in various orders as known in the art. In an alternative format, the emulsions sensitive to each of the three primary regions of the spectrum can be disposed as a single segmented layer. A single color element may comprise a combination of couplers in one or more common layers which upon processing together form a monocolour, including black or gray, (so-called chromogenic black and white) dye image.

[0051] A typical color photographic element comprises a support bearing a cyan dye image-forming unit comprised of at least one red-sensitive silver halide emulsion layer having associated therewith at least one cyan dye-forming coupler, a magenta dye image-forming unit comprising at least one green-sensitive silver halide emulsion layer having associated therewith at least one magenta dye-forming coupler, and a yellow dye image-forming unit comprising at least one blue-sensitive silver halide emulsion layer having associated therewith at least one yellow dye-forming coupler. The element can contain additional layers, such as filter layers, interlayers, overcoat layers, or subbing layers.

[0052] If desired, the photographic element can be used in conjunction with an applied magnetic layer as described  
 55 in *Research Disclosure*, November 1992, Item 34390 published by Kenneth Mason Publications, Ltd., Dudley Annex, 12a North Street, Emsworth, Hampshire PO10 7DQ, ENGLAND, and as described in Hatsumi Kyokai Koukai Gihou No. 94-6023, published March 15, 1994, available from the Japanese Patent Office. When it is desired to employ the inventive materials in a small format film, *Research Disclosure*, June 1994, Item 36230, provides suitable embodiments.

[0053] In the following discussion of suitable materials for use in the emulsions and elements of this invention, reference will be made to Research Disclosure, September 1996, Item 38957, available as described above, which is referred to herein by the term "Research Disclosur.". The Sections hereafter identified are sections of the Research Disclosure.

5 [0054] Except as provided, the silver halide emulsion containing elements employed in this invention can be either negative-working or positive-working as indicated by the type of processing instructions (i.e. color negative, reversal, or direct positive processing) provided with the element. Suitable emulsions and their preparation as well as methods of chemical and spectral sensitization are described in Sections 1 through V. Various additives such as UV dyes, brighteners, antifoggants, stabilizers, light absorbing and scattering materials, and physical property modifying addenda such as hardeners, coating aids, plasticizers, lubricants and matting agents are described, for example, in Sections II and VI  
10 through VIII. Color materials are described in Sections X through XIII. Suitable methods for incorporating couplers and dyes, including dispersions in organic solvents, are described in Section X(E). Scan facilitating is described in Section XIV. Supports, exposure, development systems, and processing methods and agents are described in Sections XV to XX. The information contained in the September 1994 Research Disclosure, Item No. 36544 referenced above, is updated in the September 1996 Research Disclosure, Item No. 38957. Certain desirable photographic elements and processing steps, including those useful in conjunction with color reflective prints, are described in Research Disclosure, Item 37038, February 1995.

[0055] Coupling-off groups are well known in the art. Such groups can determine the chemical equivalency of a coupler, i.e., whether it is a 2-equivalent or a 4-equivalent coupler, or modify the reactivity of the coupler. Such groups can advantageously affect the layer in which the coupler is coated, or other layers in the photographic recording material, by performing, after release from the coupler, functions such as dye formation, dye hue adjustment, development acceleration or inhibition, bleach acceleration or inhibition, electron transfer facilitation or color correction.

[0056] The presence of hydrogen at the coupling site provides a 4-equivalent coupler, and the presence of another coupling-off group usually provides a 2-equivalent coupler. Representative classes of such coupling-off groups include,  
25 for example, chloro, alkoxy, aryloxy, hetero-oxy, sulfonyloxy, acyloxy, acyl, heterocyclyl, sulfonamido, mercaptotetrazole, benzothiazole, mercaptopropionic acid, phosphonyloxy, arylthio, and arylazo. These coupling-off groups are described in the art, for example, in U.S. Pat. Nos. 2,455,169, 3,227,551, 3,432,521, 3,476,563, 3,617,291, 3,880,661, 4,052,212 and 4,134,766; and in UK. Patents and published application Nos. 1,466,728, 1,531,927, 1,533,039, 2,006,755A and 2,017,704A.

30 [0057] Image dye-forming couplers may be included in the element such as couplers that form cyan dyes upon reaction with oxidized color developing agents which are described in such representative patents and publications as: "Farbkuppler-eine Literature Übersicht," published in Agfa Mitteilungen, Band III, pp. 156-175 (1961) as well as in U.S. Patent Nos. 2,367,531; 2,423,730; 2,474,293; 2,772,162; 2,895,826; 3,002,836; 3,034,892; 3,041,236; 4,333,999; 4,746,602; 4,753,871; 4,770,988; 4,775,616; 4,818,667; 4,818,672; 4,822,729; 4,839,267; 4,840,883; 4,849,328;  
35 4,865,961; 4,873,183; 4,883,746; 4,900,656; 4,904,575; 4,916,051; 4,921,783; 4,923,791; 4,950,585; 4,971,898; 4,990,436; 4,996,139; 5,008,180; 5,015,565; 5,011,765; 5,011,766; 5,017,467; 5,045,442; 5,051,347; 5,061,613; 5,071,737; 5,075,207; 5,091,297; 5,094,938; 5,104,783; 5,178,993; 5,813,729; 5,187,057; 5,192,651; 5,200,305 5,202,224; 5,206,130; 5,208,141; 5,210,011; 5,215,871; 5,223,386; 5,227,287; 5,256,526; 5,258,270; 5,272,051; 5,306,610; 5,326,682; 5,366,856; 5,378,596; 5,380,638; 5,382,502; 5,384,236; 5,397,691; 5,415,990; 5,434,034;  
40 5,441,863; EPO 0 246 616; EPO 0 250 201; EPO 0 271 323; EPO 0 295 632; EPO 0 307 927; EPO 0 333 185; EPO 0 378 898; EPO 0 389 817; EPO 0 487 111; EPO 0 488 248; EPO 0 539 034; EPO 0 545 300; EPO 0 556 700; EPO 0 556 777; EPO 0 556 858; EPO 0 569 979; EPO 0 608 133; EPO 0 636 936; EPO 0 651 286; EPO 0 690 344; German OLS 4,026,903; German OLS 3,624,777, and German OLS 3,823,049. Typically such couplers are phenols, naphthols, or pyrazoloazoles.

45 [0058] Couplers that form magenta dyes upon reaction with oxidized color developing agent are described in such representative patents and publications as: "Farbkuppler-eine Literature Übersicht," published in Agfa Mitteilungen, Band III, pp. 126-156 (1961) as well as U.S. Patents 2,311,082 and 2,369,489; 2,343,701; 2,600,788; 2,908,573; 3,062,653; 3,152,896; 3,519,429; 3,758,309; 3,935,015; 4,540,654; 4,745,052; 4,762,775; 4,791,052; 4,812,576; 4,835,094; 4,840,877; 4,845,022; 4,853,319; 4,868,099; 4,865,960; 4,871,652; 4,876,182; 4,892,805; 4,900,657;  
50 4,910,124; 4,914,013; 4,921,968; 4,929,540; 4,933,465; 4,942,116; 4,942,117; 4,942,118; U.S. Patent 4,959,480; 4,968,594; 4,988,614; 4,992,361; 5,002,864; 5,021,325; 5,066,575; 5,068,171; 5,071,739; 5,100,772; 5,110,942; 5,116,990; 5,118,812; 5,134,059; 5,155,016; 5,183,728; 5,234,805; 5,235,058; 5,250,400; 5,254,446; 5,262,292; 5,300,407; 5,302,496; 5,336,593; 5,350,667; 5,395,968; 5,354,826; 5,358,829; 5,368,998; 5,378,587; 5,409,808; 5,411,841; 5,418,123; 5,424,179; EPO 0 257 854; EPO 0 284 240; EPO 0 341 204; EPO 347,235; EPO 365,252; EPO  
55 0 422 595; EPO 0 428 899; EPO 0428 902; EPO 0 459 331; EPO 0 467 327; EPO 0 476 949; EPO 0 487 081; EPO 0 489 333; EPO 0 512 304; EPO 0 515 128; EPO 0 534 703; EPO 0 554 778; EPO 0 558 145; EPO 0 571 959; EPO 0 583 832; EPO 0 583 834; EPO 0 584 793; EPO 0 602 748; EPO 0 602 749; EPO 0 605 918; EPO 0 622 672; EPO 0 622 673; EPO 0 629 912; EPO 0 646 841; EPO 0 656 561; EPO 0 660 177; EPO 0 686 872; WO 90/10253; WO

92/09010; WO 92/10788; WO 92/12464; WO 93/01523; WO 93/02392; WO 93/02393; WO 93/07534; UK Application 2,244,053; Japanese Application 03192-350; German OLS 3,624,103; German OLS 3,912,265; and German OLS 4008 067. Typically such couplers are pyrazolones, pyrazoloazoles, or pyrazolobenzimidazoles that form magenta dyes upon reaction with oxidized color developing agents.

5 **[0059]** Couplers that form yellow dyes upon reaction with oxidized color developing agent are described in such representative patents and publications as: "Farbkuppler-eine Literature Übersicht," published in Agfa Mitteilungen; Band III; pp. 112-126 (1961); as well as U.S. Patent 2,298,443; 2,407,210; 2,875,057; 3,048,194; 3,265,506; 3,447,928; 4,022,620; 4,443,536; 4,758,501; 4,791,050; 4,824,771; 4,824,773; 4,855,222; 4,978,605; 4,992,360; 4,994,361; 5,021,333; 5,053,325; 5,066,574; 5,066,576; 5,100,773; 5,118,599; 5,143,823; 5,187,055; 5,190,848; 5,213,958; 10 5,215,877; 5,215,878; 5,217,857; 5,219,716; 5,238,803; 5,283,166; 5,294,531; 5,306,609; 5,328,818; 5,336,591; 5,338,654; 5,358,835; 5,358,838; 5,360,713; 5,362,617; 5,382,506; 5,389,504; 5,399,474; 5,405,737; 5,411,848; 5,427,898; EPO 0 327 976; EPO 0 296 793; EPO 0 365 282; EPO 0 379 309; EPO 0 415 375; EPO 0 437 818; EPO 0 447 969; EPO 0 542 463; EPO 0 568 037; EPO 0 568 196; EPO 0 568 777; EPO 0 570 006; EPO 0 573 761; EPO 0 608 956; EPO 0 608 957; and EPO 0 628 865. Such couplers are typically open chain ketomethylene compounds.

15 **[0060]** Couplers that form colorless products upon reaction with oxidized color developing agent are described in such representative patents as: UK. 861,138; U.S. Pat. Nos. 3,632,345; 3,928,041; 3,958,993 and 3,961,959. Typically such couplers are cyclic carbonyl containing compounds that form colorless products on reaction with an oxidized color developing agent.

**[0061]** Couplers that form black dyes upon reaction with oxidized color developing agent are described in such representative patents as U.S. Patent Nos. 1,939,231; 2,181,944; 2,333,106; and 4,126,461; German OLS No. 2,644,194 and German OLS No. 2,650,764. Typically, such couplers are resorcinols or m-aminophenols that form black or neutral products on reaction with oxidized color developing agent.

**[0062]** In addition to the foregoing, so-called "universal" or "washout" couplers may be employed. These couplers do not contribute to image dye-formation. Thus, for example, a naphthol having an unsubstituted carbamoyl or one substituted with a low molecular weight substituent at the 2- or 3- position may be employed. Couplers of this type are described, for example, in U.S. Patent Nos. 5,026,628, 5,151,343, and 5,234,800.

**[0063]** It may be useful to use a combination of couplers any of which may contain known ballasts or coupling-off groups such as those described in U.S. Patent 4,301,235; U.S. Patent 4,853,319 and U.S. Patent 4,351,897. The coupler may contain solubilizing groups such as described in U.S. Patent 4,482,629. The coupler may also be used in association with "wrong" colored couplers (e.g. to adjust levels of interlayer correction) and, in color negative applications, with masking couplers such as those described in EP 213,490; Japanese Published Application 58-172,647; U.S. Patent Nos. 2,983,608; 4,070,191; and 4,273,861; German Applications DE 2,706,117 and DE 2,643,965; UK. Patent 1,530,272; and Japanese Application 58-113935. The masking couplers may be shifted or blocked, if desired.

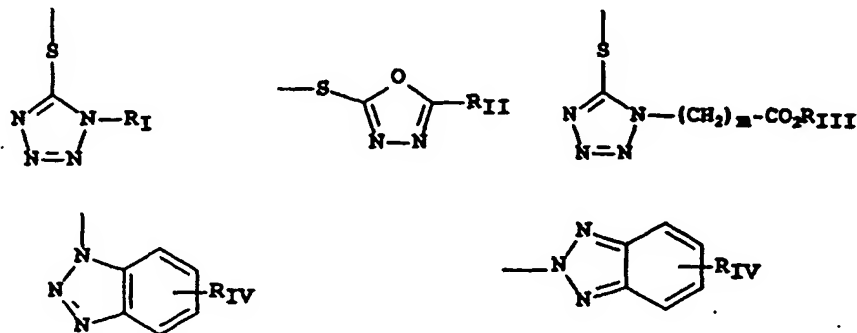
30 **[0064]** The materials useful in the invention may be used in association with materials that release Photographically Useful Groups (PUGS) that accelerate or otherwise modify the processing steps e.g. of bleaching or fixing to improve the quality of the image. Bleach accelerator releasing couplers such as those described in EP 193,389; EP 301,477; U.S. 4,163,669; U.S. 4,865,956; and U.S. 4,923,784, may be useful. Also contemplated is use of the compositions in association with nucleating agents, development accelerators or their precursors (UK Patent 2,097,140; UK. Patent 2,131,188); electron transfer agents (U.S. 4,859,578; U.S. 4,912,025); antifogging and anti color-mixing agents such as derivatives of hydroquinones, aminophenols, amines, gallic acid; catechol; ascorbic acid; hydrazides; sulfonamidophenols; and non color-forming couplers.

**[0065]** The materials useful in the invention may also be used in combination with filter dye layers comprising yellow, cyan, and/or magenta filter dyes, either as oil-in-water dispersions, latex dispersions or as solid particle dispersions. Additionally, they may be used with "smearing" couplers (e.g. as described in U.S. 4,366,237; EP 96,570; U.S. 4,420,556; and U.S. 4,543,323.) Also, the compositions may be blocked or coated in protected form as described, for example, in Japanese Application 61/258,249 or U.S. 5,019,492.

45 **[0066]** The materials useful in the invention may further be used in combination with image-modifying compounds that release PUGS such as "Developer Inhibitor-Releasing" compounds (DIRs). DIRs useful in conjunction with the compositions of the invention are known in the art and examples are described in U.S. Patent Nos. 3,137,578; 3,148,022; 3,148,062; 3,227,554; 3,384,657; 3,379,529; 3,615,506; 3,617,291; 3,620,746; 3,701,783; 3,733,201; 50 4,049,455; 4,095,984; 4,126,459; 4,149,886; 4,150,228; 4,211,562; 4,248,962; 4,259,437; 4,362,878; 4,409,323; 4,477,563; 4,782,012; 4,962,018; 4,500,634; 4,579,816; 4,607,004; 4,618,571; 4,678,739; 4,746,600; 4,746,601; 4,791,049; 4,857,447; 4,865,959; 4,880,342; 4,886,736; 4,937,179; 4,946,767; 4,948,716; 4,952,485; 4,956,269; 4,959,299; 4,966,835; 4,985,336 as well as in patent publications GB 1,560,240; GB 2,007,662; GB 2,032,914; GB 2,099,167; DE 2,842,063; DE 2,937,127; DE 3,636,824; DE 3,644,416 as well as the following European Patent Publications: 272,573; 335,319; 336,411; 346, 899; 362, 870; 365,252; 365,346; 373,382; 376,212; 377,463; 378,236; 384,670; 396,486; 401,612; 401,613.

**[0067]** Such compounds are also disclosed in "Developer-Inhibitor-Releasing (DIR) Couplers for Color Photogra-

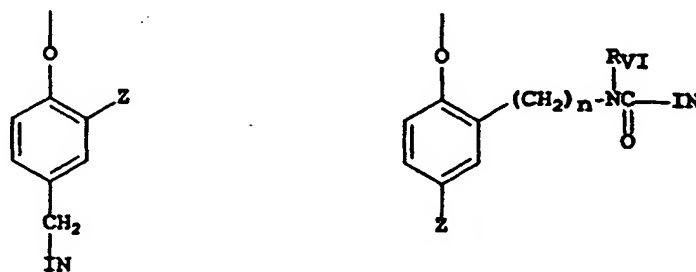
phy," C.R. Barr, J.R. Thirtle and P.W. Vittum in *Photographic Science and Engineering*, Vol. 13, p. 174 (1969). Generally, the developer inhibitor-releasing (DIR) couplers include a coupler moiety and an inhibitor coupling-off moiety (IN). The inhibitor-releasing couplers may be of the time-delayed type (DIAR couplers) that also include a timing moiety or chemical switch which produces a delayed release of inhibitor. Examples of typical inhibitor moieties are: oxazoles, thiazoles, diazoles, triazoles, oxadiazoles, thiadiazoles, oxathiazoles, thiatriazoles, benzotriazoles, tetrazoles, benzimidazoles, indazoles, isoindazoles, mercaptotetrazoles, selenotetrazoles, mercaptobenzothiazoles, selenobenzothiazoles, mercaptobenzoxazoles, selenobenzoxazoles, mercaptobenzimidazoles, selenobenzimidazoles, benzodiazoles, mercaptooxazoles, mercaptothiadiazoles, mercaptothiazoles, mercaptotriazoles, mercaptooxadiazoles, mercaptodiazoles, mercaptooxathiazoles, tellurotetrazoles or benzisodiazoles. In a preferred embodiment, the inhibitor moiety or group is selected from the following formulas:



wherein  $R_I$  is selected from the group consisting of straight and branched alkyls of from 1 to about 8 carbon atoms, benzyl, phenyl, and alkoxy groups and such groups containing none, one or more than one such substituent;  $R_{II}$  is selected from  $R_I$  and  $-SR_I$ ;  $R_{III}$  is a straight or branched alkyl group of from 1 to about 5 carbon atoms and  $m$  is from 1 to 3; and  $R_{IV}$  is selected from the group consisting of hydrogen, halogens and alkoxy, phenyl and carbonamido groups,  $-COOR_V$  and  $-NHCOOR_V$  wherein  $R_V$  is selected from substituted and unsubstituted alkyl and aryl groups.

**[0068]** Although it is typical that the coupler moiety included in the developer inhibitor-releasing coupler forms an image dye corresponding to the layer in which it is located, it may also form a different color as one associated with a different film layer. It may also be useful that the coupler moiety included in the developer inhibitor-releasing coupler forms colorless products and/or products that wash out of the photographic material during processing (so-called "universal" couplers).

**[0069]** A compound such as a coupler may release a PUG directly upon reaction of the compound during processing, or indirectly through a timing or linking group. A timing group produces the time-delayed release of the PUG such groups using an intramolecular nucleophilic substitution reaction (U.S. 4,248,962); groups utilizing an electron transfer reaction along a conjugated system (U.S. 4,409,323; 4,421,845; 4,861,701, Japanese Applications 57-188035; 58-98728; 58-209736; 58-209738); groups that function as a coupler or reducing agent after the coupler reaction (U.S. 4,438,193; U.S. 4,618,571) and groups that combine the features described above. It is typical that the timing group is of one of the formulas:

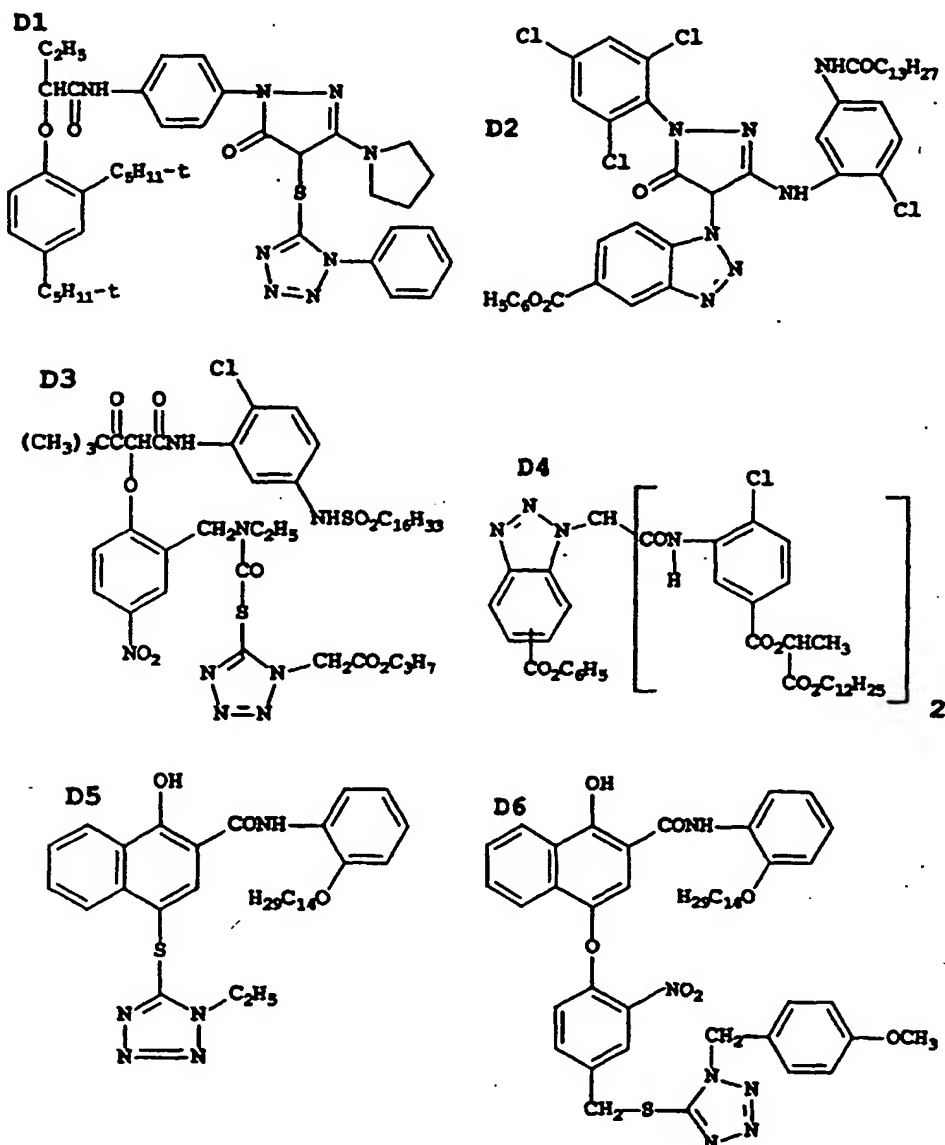


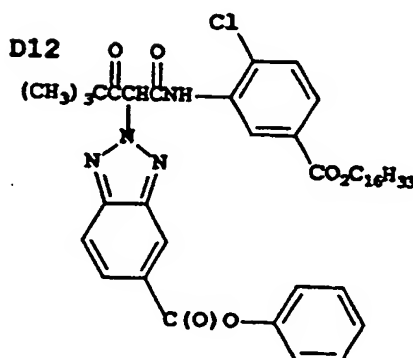
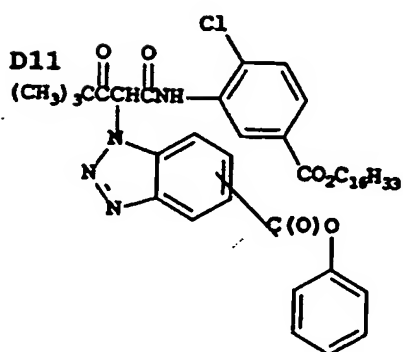
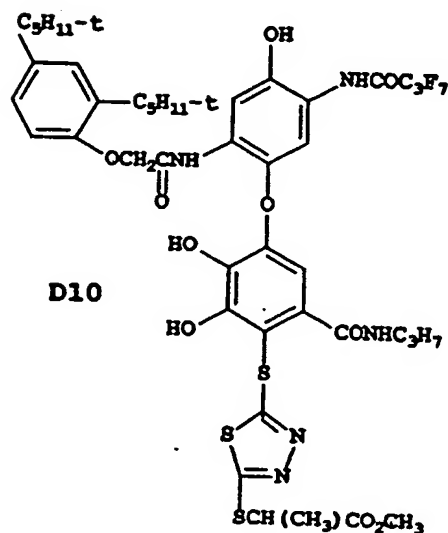
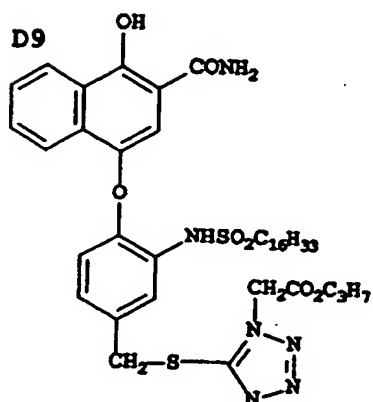
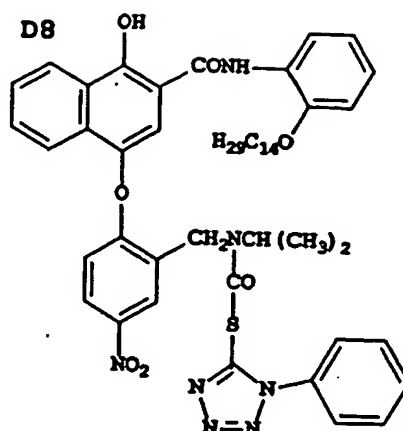
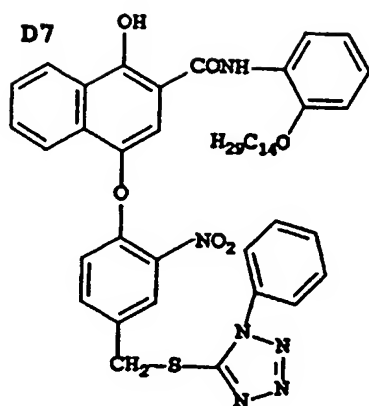
wherein IN is the inhibitor moiety, Z is selected from the group consisting of nitro, cyano, alkylsulfonyl; sulfamoyl (-

SO<sub>2</sub>NR<sub>2</sub>); and sulfonamido (-NRSO<sub>2</sub>R) groups; n is 0 or 1; and R<sub>V1</sub> is selected from the group consisting of substituted and unsubstituted alkyl and phenyl groups. The oxygen atom of each timing group is bonded to the coupling-off position of the respective coupler moiety of the DIAR.

[0070] The timing or linking groups may also function by electron transfer down an unconjugated chain. Linking groups are known in the art under various names. Often they have been referred to as groups capable of utilizing a hemiacetal or iminoketal cleavage reaction or as groups capable of utilizing a cleavage reaction due to ester hydrolysis such as U.S. 4,546,073. This electron transfer down an unconjugated chain typically results in a relatively fast decomposition and the production of carbon dioxide, formaldehyde, or other low molecular weight by-products. The groups are exemplified in EP 464,612, EP 523,451, U.S. 4,146,396, Japanese Kokai 60-249148 and 60-249149.

[0071] Suitable developer inhibitor-releasing couplers that may be included in photographic light sensitive emulsion layer include, but are not limited to, the following:





[0072] Especially useful in this invention are tabular grain silver halide emulsions. Tabular grains are those having two parallel major crystal faces and having an aspect ratio of at least 2. The term "aspect ratio" is the ratio of the equivalent circular diameter (ECD) of a grain major face divided by its thickness (t). The major faces of the tabular grains can

lie in either {111} or {100} crystal planes. Specifically contemplated tabular grain emulsions are those in which greater than 50 percent of the total projected area of the emulsion grains are accounted for by tabular grains having a thickness of less than 0.3 micrometer (0.5 micrometer for blue sensitive emulsion) and an average tabularity (T) of greater than 25 (preferably greater than 100), where the term "tabularity" is employed in its art recognized usage as

5

$$T = ECD/t^2$$

where

10 ECD is the average equivalent circular diameter of the tabular grains in micrometers and  
t is the average thickness in micrometers of the tabular grains.

[0073] The average useful ECD of photographic emulsions can range up to 10 micrometers, although in practice emulsion ECDs seldom exceed 4 micrometers. Since both photographic speed and granularity increase with increasing  
15 ECDs, it is generally preferred to employ the smallest tabular grain ECDs compatible with achieving aim speed requirements.

[0074] Emulsion tabularity increases markedly with reductions in tabular grain thickness. It is generally preferred that aim tabular grain projected areas be satisfied by thin ( $t < 0.2$  micrometer) tabular grains. To achieve the lowest levels of granularity it is preferred that aim tabular grain projected areas be satisfied with ultrathin ( $t < 0.07$  micrometer)  
20 tabular grains. Tabular grain thicknesses typically range down to 0.02 micrometer. However, still lower tabular grain thicknesses are contemplated. For example, Daubendiek *et al.* U.S. Patent 4,672,027 reports a 3 mol percent iodide tabular grain silver bromide emulsion having a grain thickness of 0.017 micrometer. Ultrathin tabular grain high chloride emulsions are disclosed by Maskasky U.S. 5,217,858.

[0075] As noted above tabular grains of less than the specified thickness account for at least 50 percent of the total grain projected area of the emulsion. To maximize the advantages of high tabularity it is generally preferred that tabular grains satisfying the stated thickness criterion account for the highest conveniently attainable percentage of the total grain projected area of the emulsion. For example, in preferred emulsions, tabular grains satisfying the stated thickness  
25 criteria above account for at least 70 percent of the total grain projected area. In the highest performance tabular grain emulsions, tabular grains satisfying the thickness criteria above account for at least 90 percent of total grain projected area.

Suitable tabular grain emulsions can be selected from among a variety of conventional teachings, such as those of the following: Research Disclosure, Item 22534, January 1983, published by Kenneth Mason Publications, Ltd., Emsworth, Hampshire PO10 7DD, England; U.S. Patent Nos. 4,439,520; 4,414,310; 4,433,048; 4,643,966; 4,647,528; 4,665,012; 4,672,027; 4,678,745; 4,693,964; 4,713,320; 4,722,886; 4,755,456; 4,775,617; 4,797,354; 4,801,522; 4,806,461; 4,835,095; 4,853,322; 4,914,014; 4,962,015; 4,985,350; 5,061,069 and 5,061,616. Tabular grain emulsions consisting  
35 predominantly of silver chloride are useful and are described, for example, in U.S. 5,310,635; 5,320,938; and 5,356,764.

[0076] In their most widely used form tabular grain emulsions are high bromide {111} tabular grain emulsions. Such emulsions are illustrated by Kofron *et al.* U.S. Patent 4,439,520, Wilgus *et al.* U.S. Patent 4,434,226, Solberg *et al.* U.S. Patent 4,433,048, Maskasky U.S. Patents 4,435,501, 4,463,087 and 4,173,320, Daubendiek *et al.* U.S. Patents 4,414,310 and 4,914,014, Sowinski *et al.* U.S. Patent 4,656,122, Piggin *et al.* U.S. Patents 5,061,616 and 5,061,609, Tsaor *et al.* U.S. Patents 5,147,771, 5,147,772, 5,147,773, 5,171,659 and 5,252,453, Black *et al.* 5,219,720 and 5,334,495, Delton U.S. Patents 5,310,644, 5,372,927 and 5,460,934, Wen U.S. Patent 5,470,698, Fenton *et al.* U.S. Patent 5,476,760, Eshelman *et al.* U.S. Patents 5,612,175 and 5,614,359, and Irving *et al.* U.S. Patent 5,667,954.

45 [0077] Ultrathin high bromide {111} tabular grain emulsions are illustrated by Daubendiek *et al.* U.S. Patents 4,672,027, 4,693,964, 5,494,789, 5,503,971 and 5,576,168, Antoniadis *et al.* U.S. Patent 5,250,403, Olm *et al.* U.S. Patent 5,503,970, Deaton *et al.* U.S. Patent 5,582,965, and Maskasky U.S. Patent 5,667,955.

[0078] High bromide {100} tabular grain emulsions are illustrated by Mignot U.S. Patents 4,386,156 and 5,386,156.

[0079] High chloride {111} tabular grain emulsions are illustrated by Wey U.S. Patent 4,399,215, Wey *et al.* U.S. Patent 4,414,306, Maskasky U.S. Patents 4,400,463, 4,713,323, 5,061,617, 5,178,997, 5,183,732, 5,185,239, 5,399,478 and 5,411,852, and Maskasky *et al.* U.S. Patents 5,176,992 and 5,178,998. Ultrathin high chloride {111} tabular grain emulsions are illustrated by Maskasky U.S. Patents 5,271,858 and 5,389,509.

[0080] High chloride {100} tabular grain emulsions are illustrated by Maskasky U.S. Patents 5,264,337, 5,292,632, 5,275,930 and 5,399,477, House *et al.* U.S. Patent 5,320,938, Brust *et al.* U.S. Patent 5,314,798, Szajewski *et al.* U.S. Patent 5,356,764, Chang *et al.* U.S. Patents 5,413,904 and 5,663,041, Oyamada U.S. Patent 5,593,821, Yamashita *et al.* U.S. Patents 5,641,620 and 5,652,088, Saitou *et al.* U.S. Patent 5,652,089, and Oyamada *et al.* U.S. Patent 5,665,530. Ultrathin high chloride {100} tabular grain emulsions can be prepared by nucleation in the presence of iodide, following the teaching of House *et al.* and Chang *et al.*, cited above.

[0081] The emulsions can be surface-sensitive emulsions, i.e., emulsions that form latent images primarily on the surfaces of the silver halide grains, or the emulsions can form internal latent images predominantly in the interior of the silver halide grains. The emulsions can be negative-working emulsions, such as surface-sensitive emulsions or unfogged internal latent image-forming emulsions, or direct-positive emulsions of the unfogged, internal latent image-forming type, which are positive-working when development is conducted with uniform light exposure or in the presence of a nucleating agent. Tabular grain emulsions of the latter type are illustrated by Evans et al. U.S. 4,504,570.

[0082] Photographic elements can be exposed to actinic radiation, typically in the visible region of the spectrum, to form a latent image and can then be processed to form a visible dye image. Processing to form a visible dye image includes the step of contacting the element with a color developing agent to reduce developable silver halide and oxidize the color developing agent. Oxidized color developing agent in turn reacts with the coupler to yield a dye.

[0083] With negative-working silver halide, the processing step described above provides a negative image. One type of such element, referred to as a color negative film, is designed for image capture. Speed (the sensitivity of the element to low light conditions) is usually critical to obtaining sufficient image in such elements. Such elements are typically silver bromiodide emulsions and may be processed, for example, in known color negative processes such as the Kodak C-41™ process as described in The British Journal of Photography Annual of 1988, pages 191-198. If a color negative film element is to be subsequently employed to generate a viewable projection print as for a motion picture, a process such as the Kodak ECN-2™ process described in the H-24 Manual available from Eastman Kodak Co. may be employed to provide the color negative image on a transparent support. Color negative development times are typically 3 minutes 15 seconds.

[0084] The photographic element of the invention can be incorporated into exposure structures intended for repeated use or exposure structures intended for limited use, variously referred to by names such as "single use cameras", "lens with film", or "photosensitive material package units".

[0085] A reversal element is capable of forming a positive image without optical printing. To provide a positive (or reversal) image, the color development step is preceded by development with a non-chromogenic developing agent to develop exposed silver halide, but not form dye, and followed by uniformly fogging the element to render unexposed silver halide developable. Such reversal emulsions are typically sold with instructions to process using a color reversal process such as the Kodak E-6™ process. Alternatively, a direct positive emulsion can be employed to obtain a positive image.

[0086] The above emulsions are typically sold with instructions to process using the appropriate method such as the mentioned color negative (Kodak C-41™) or reversal (Kodak E-6™) process.

[0087] Preferred color developing agents are *p*-phenylenediamines such as:

4-amino-N,N-diethylaniline hydrochloride,  
4-amino-3-methyl-N,N-diethylaniline hydrochloride,  
4-amino-3-methyl-N-ethyl-N-(2-methanesulfonamidoethyl)aniline sesquisulfate hydrate,  
4-amino-3-methyl-N-ethyl-N-(2-hydroxyethyl)aniline sulfate,  
4-amino-3-(2-methanesulfonamidoethyl)-N,N-diethylaniline hydrochloride, and  
4-amino-N-ethyl-N-(2-methoxyethyl)-*m*-toluidine di-*p*-toluene sulfonic acid.

[0088] Of the above, developers based on 4-amino-3-methyl-N-ethyl-N-(2-hydroxyethyl)aniline and 4-amino-3-methyl-N-ethyl-N-(2-methanesulfonamidoethyl)aniline are especially preferred. Moreover, because the compounds of the invention give increased light sensitivity, they are especially useful in processes that have shortened development times. In particular, the film elements of the invention can be processed with development times of less than 3.25 minutes or even less than 3 minutes or in extreme cases; even less than 120 seconds.

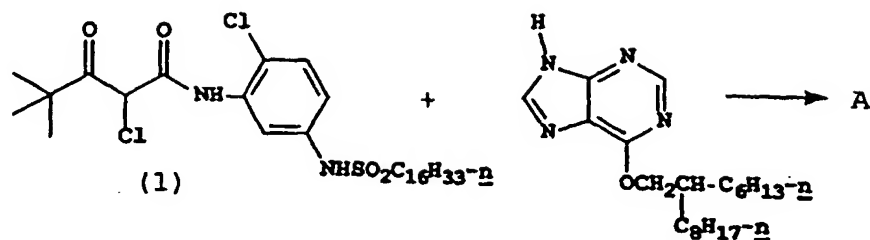
[0089] Development is usually followed by the conventional steps of bleaching, fixing, or bleach-fixing, to remove silver or silver halide, washing, and drying.



**Synthesis Example**

## Preparation of Coupler A:

[0090]



[0091] Triethylamine (29ml, 206mmol) was added to a stirred suspension of compound CC-1 (25.00g, 69.35mmol) and (1) (40.91g, 69.35mmol) in dry DMF (200 ml) causing the solids to dissolve. The solution was heated at 60°C for 4h. The reaction was allowed to cool to room temperature then added with stirring to water (31) containing concentrated hydrochloric acid (280ml). The aqueous solution was decanted away from the solid which was then dissolved in ether (500ml). The organic solution was washed with water (3x300ml), dried (magnesium sulfate) and concentrated *in vacuo*. The residual oil was purified by column chromatography over silica gel (eluent first 9:1: petrol ether/ethyl acetate then 4:1 petrol ether/ ethyl acetate). This gave the coupler A (25.15g, 27.5mmol, 40%) as a brown glass.

**Photographic Examples.**

[0092] A single layer film demonstrating the invention was produced by coating the following layers over a gelatin pad of 2.7 on a cellulose triacetate film support (coverage are in grams per meter squared). The imaging layer was coated by combining immediately before coating two separate melts (A and B) in a 1:1 ratio.

**Example SL-1:****Layer 1 (Imaging Layer):**

[0093]

Melt A: gelatin at 1.62 and yellow image coupler Y-1 at 0.87.

Melt B: gelatin at 1.62 and a blend of two blue sensitized silver iodobromide emulsions at a total of 0.972.

**Layer 2 (Overcoat):** gelatin at 5.4 and 0.204 of bis-vinylmethylsulfonemethylether hardener.

[0094] Example SL-2 was prepared like SL-1 except 0.039 of CC-1 (dispersed in twice its weight of N,N-dibutylauramide) was added to Melt A. Example SL-3 had 0.078 of N,N-dibutylauramide (dispersed in gel) added to Melt A. SL-4 had 0.199 of N,N-dibutylauramide (dispersed in gel) added to Melt A. SL-5 had 0.099 of inventive coupler A added to Melt A. Coupler A is coated equimolar to CC-1. Examples SL-6 through SL-10 were prepared like SL-1 through SL-5 except Melts A and B were mixed together at 40 degrees C for 1 hour before coating, a condition which is typical of manufacturing conditions.

[0095] These film were exposed and processed in the KODAK FLEXICOLOR™ (C-41) process as described in *British Journal of Photography Annual*, 1988, pp 196-198 except the time of development was 2.25 minutes. The short process time with these single layer films better approximates the reduced developability of the same emulsions in multilayer films. Relative speed or light sensitivity (given in terms of fraction of a stop) was determined by comparing the exposure point +0.15 density units above  $D_{min}$  to the check position without addenda under the given exposure condition.

Table 1

Single Layer Results				
Example	Comp/Inv	Addenda	Blue Dmin	Relative Blue Speed
SL-1	Comp	-	0.106	(check)
SL-2	Comp	CC-1	0.113	$\pm 0.27$
SL-3	Comp	N,N-dibutylauramide	0.116	-0.07
SL-4	Comp	N,N-dibutylauramide	0.204	-0.30
SL-5	Inv	Coupler A	0.113	+0.13
SL-6	Comp	-	0.103	(check)
SL-7	Comp	CC-1	0.079	-1.33
SL-8	Comp	N,N-dibutylauramide	0.095	-0.03
SL-9	Comp	N,N-dibutylauramide	0.151	-0.20
SL-10	Inv	Coupler A	0.093	+0.10

[0096] The results shown in Table 1 clearly show that only the coupler of invention increases the speed of the film and avoids speed loss when the speed addenda are held together in the presence of silver halide emulsions. In particular, comparison of SL-7 (free HSM mixed with silver halide emulsion for 1 hr at 40 °C) to SL-2 (free HSM mixed with emulsion just prior to coating) shows a large loss in speed that does not occur with the invention (compare SL-10 to SL-5). Similar speed losses were obtained with other types and classes of free HSM in this format.

[0097] Multilayer films demonstrating the principles of this invention were produced by coating the following layers on a cellulose triacetate film support (coverage are in grams per meter squared, emulsion sizes as determined by the disc centrifuge method and are reported in Diameter x Thickness in micrometers).

Example ML- 1:

[0098]

**Layer 1** (Antihalation layer): gelatin at 1.62, colloidal gray silver at 0.15 1, DYE-1 at 0.013, DYE-3 at 0.108, DYE-4 at 0.037 and UV-1 and UV-2 each at 0.076.

**Layer 2** (Interlayer): gelatin at 0.54 and ILS-1 at 0.076.

**Layer 3** (Slow cyan layer): a blend of two red sensitized (all with a mixture of RSD-1 and RSD-3) silver iodobromide emulsions: (i) a large sized iodobromide tabular grain emulsion (1.25 x 0.124, 4.1 mole % I) at 0.3 13, (ii) a smaller iodobromide tabular emulsion (0.74 x 0.12, 4.1 mole % I) at 0.266, cyan dye-forming coupler C-1 at 0.228, C-2 at 0.364, bleach accelerator releasing coupler B-1 at 0.081, masking coupler MC-1 at 0.032 and gelatin at 1.67.

**Layer 4** (Mid Cyan Layer): a red-sensitized sensitized (all with a mixture of RSD-1 and RSD-3) iodobromide tabular emulsion (2.25 x 0.125, 3.1 mole % I) at 1.177, C-2 at 0.211, DIR-5 at 0.011, DIR-6 at 0.011, ILS-1 at 0.011 and gelatin at 1.62.

**Layer 5** (Fast Cyan layer): a red-sensitized sensitized (with a mixture of RSD-1 and RSD-3) iodobromide tabular emulsion (4.05 x 0.13, 3.7 mole % I) at 1.295, C-2 at 0.227, DIR-5 at 0.0.022, DIR-6 at 0.025, ILS-1 at 0.014 and gelatin at 1.49.

**Layer 6** (Interlayer): ILS-1 at 0.076 and gelatin at 0.54.

**Layer 7** (Slow magenta layer): a blend of two green sensitized (both with a mixture of GSD-1 and GSD-2) silver iodobromide tabular emulsions: (i) 0.88 x 0.12, 4.1 mole % iodide at 0.539 and (ii) 1.2 x 0.12, 4.1 mole % iodide at 0.336, magenta dye forming coupler M-1 at 0.302, masking coupler CM-2 at 0.076, and gelatin at 1.188.

**Layer 8** (Mid Magenta Layer): a green sensitized (with a mixture of GSD-1 and GSD-2) silver iodobromide tabular emulsion: (2.85 x 0.116, 3.6 mole % iodide) at 0.972, M-1 at 0.103, CM-2 at 0.086, DIR-7 at 0.011 and gelatin at 1.566.

**Layer 9** (Fast Magenta Layer): Two melts mixed together at a 1:1 ratio immediately before coating: Melt A containing gelatin at 0.54 and M-1 at 0.084 and Melt B containing gelatin at 1.08, DIR-7 at 0.003 and a green sensitized (with a mixture of GSD-1 and GSD-2) silver iodobromide tabular emulsion (3.95 x 0.14, 3.6 mole % iodide) at 1.296.

**Layer 10** (Yellow filter layer): ILS-1 at 0.076, YFD-1 at 0.108 and gelatin at 0.81.

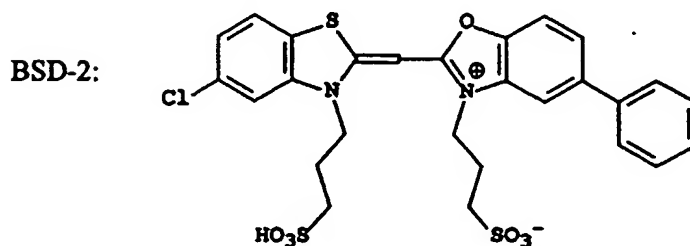
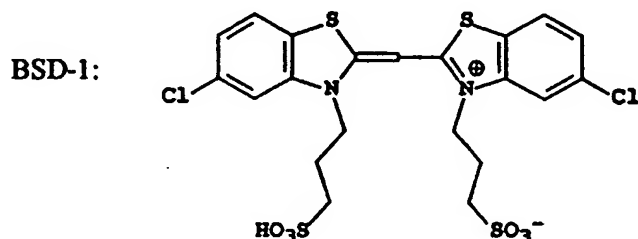
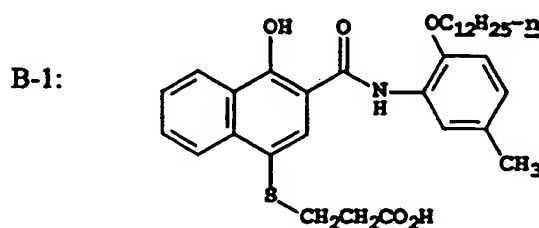
**Layer 11** (Slow Yellow Layer): a blend of three blue sensitized (all with BSD-1) tabular silver iodobromide emulsions (i) 0.54 x 0.086, 1.3 mole % I at 0.395, (ii) 0.96 x 0.26, 6 mole % I at 0.233, (iii) 1.03 x 0.13, 1.5 mole % I at 0.081, yellow dye forming coupler Y-2 at 0.735, DIR-3 at 0.027, B-1 at 0.003 and gelatin at 1.62.

**Layer 12** (Fast Yellow Layer): a blue sensitized (with BSD-1) tabular silver iodobromide emulsion (2.9 x 0.13, 4.1 mole % I) at 0.414 and a 3D silver iodobromide emulsion (1.4 diameter, 14 mole % I) at 0.905, Y-2 at 0.426, DIR-3 at 0.027, B-1 at 0.011 and gelatin at 1.706.

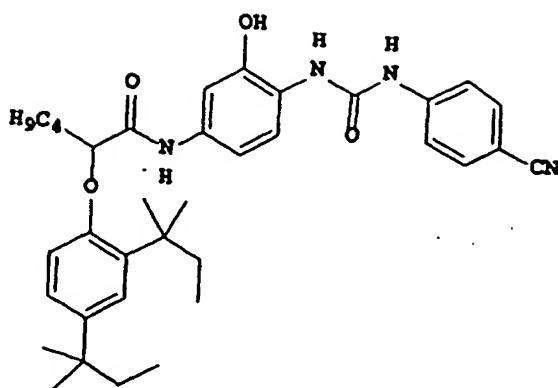
**Layer 13** (Protective Overcoat and UV Filter Layer): silver bromide Lippman emulsion at 0.216, UV-1 and UV-2 both at 0.108, gelatin at 1.242 and bis(vinylsulfonyl)methane hardener at 1.75% of total gelatin weight.

[0099] Surfactants, coating aids, emulsion addenda, sequestrants, thickeners, lubricants, matte and tinting dyes were added to the appropriate layers as is common in the art. Unless otherwise noted, the comparative or inventive examples were dispersed in twice their own weight of N,N-dibutylauramide and were added to Melt A of Layer 9 at 0.082 mmoles/m<sup>2</sup>.

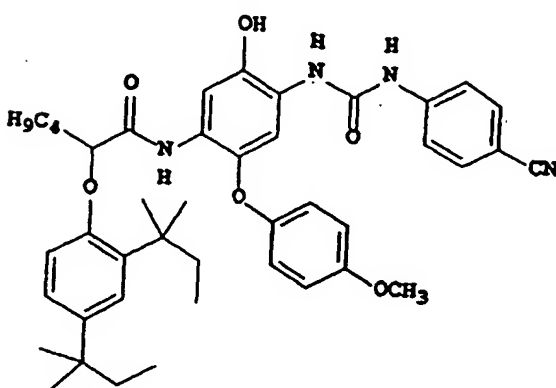
[0100] Structures of the materials used in these photographic coatings are as follows:



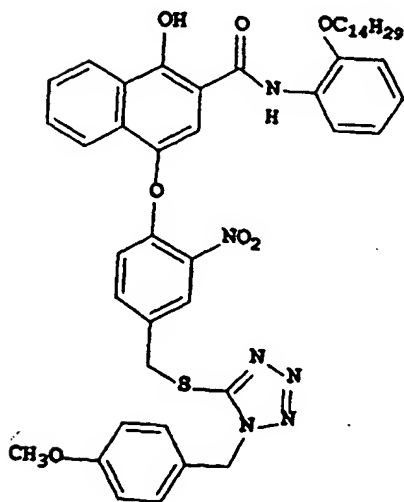
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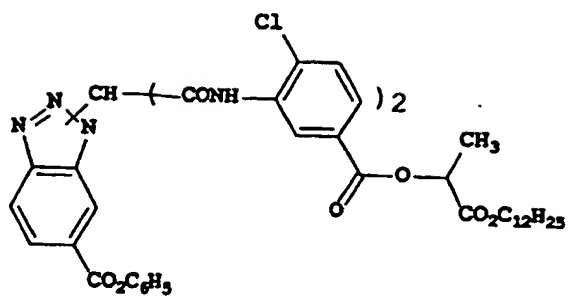
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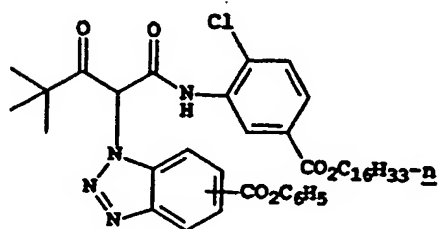
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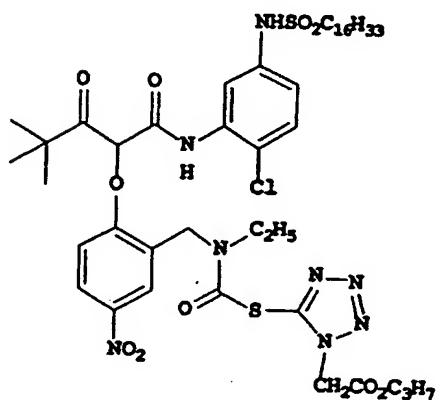
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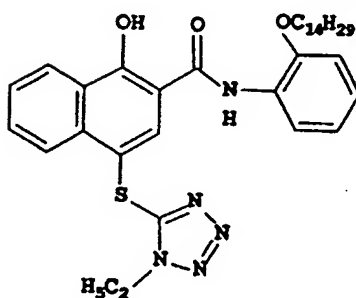
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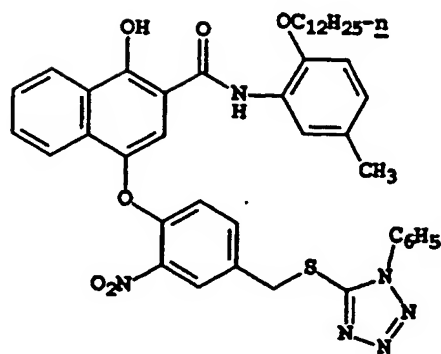
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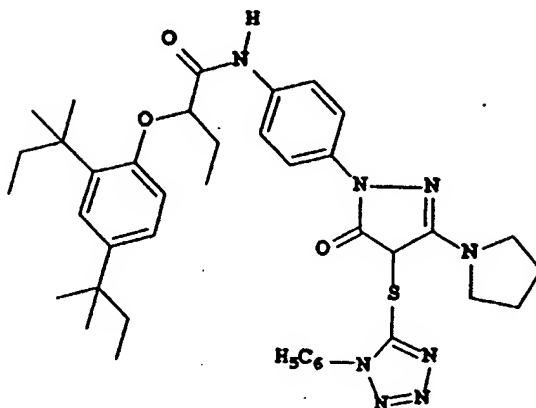
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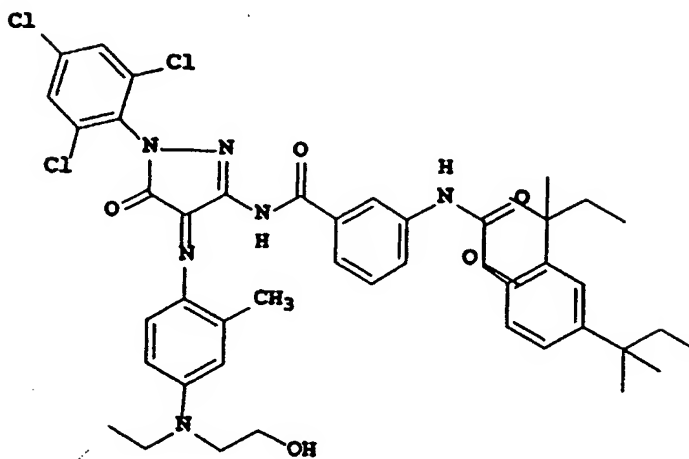
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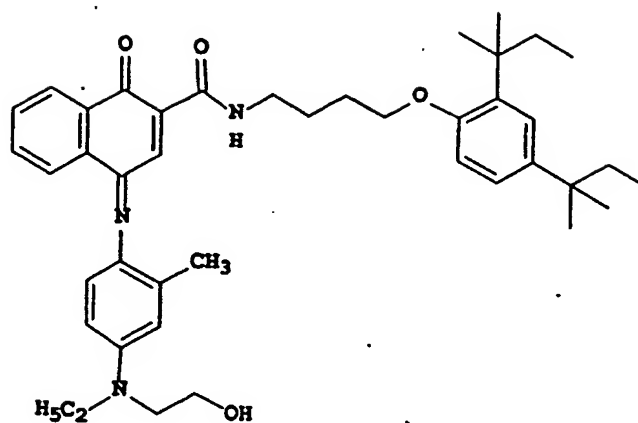
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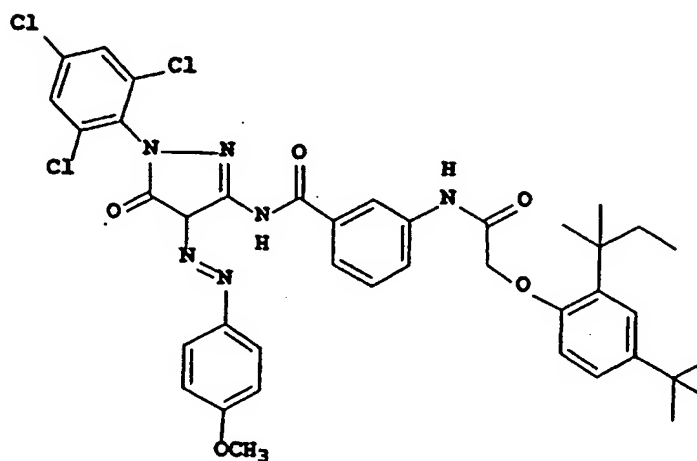
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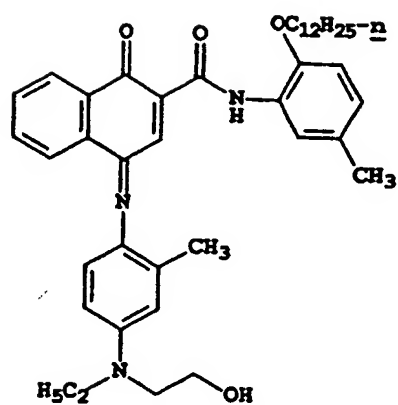
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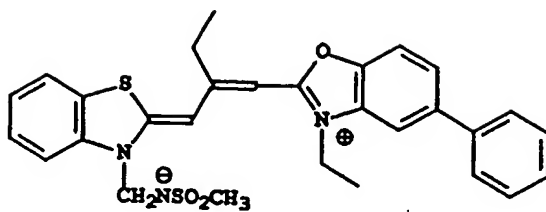
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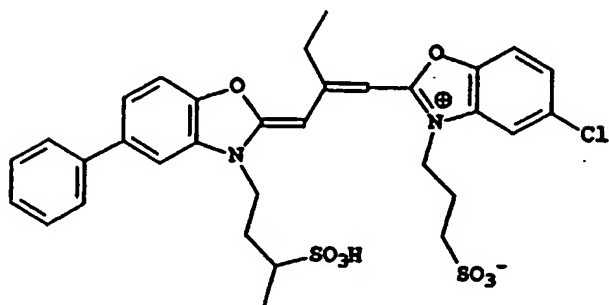
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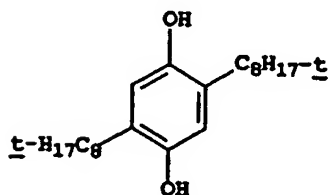
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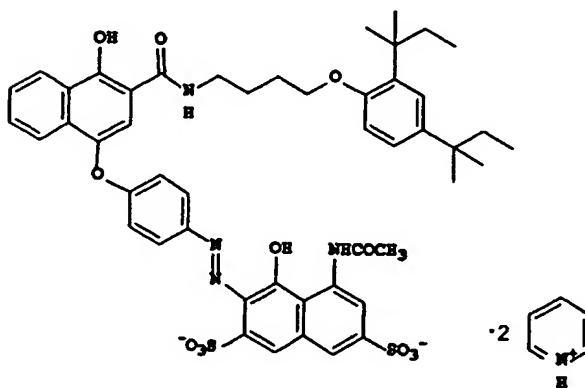
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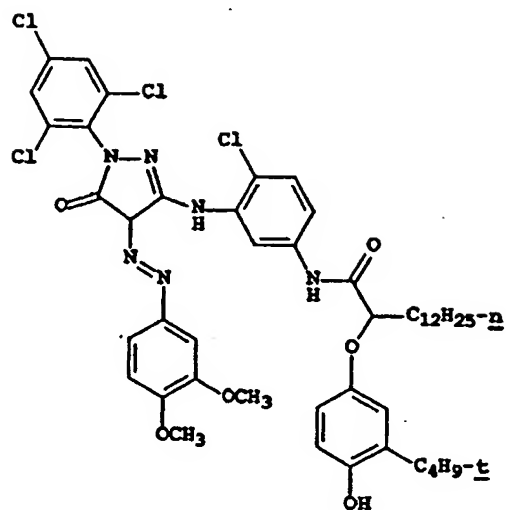


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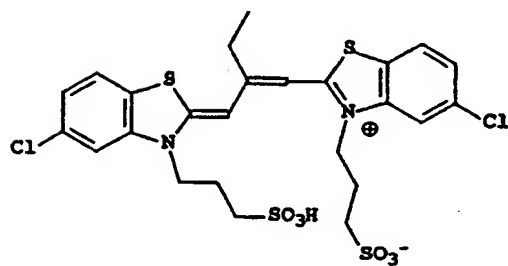




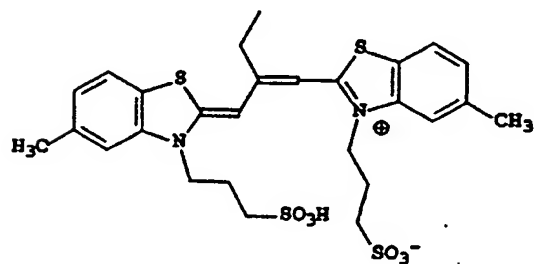
MC-2:



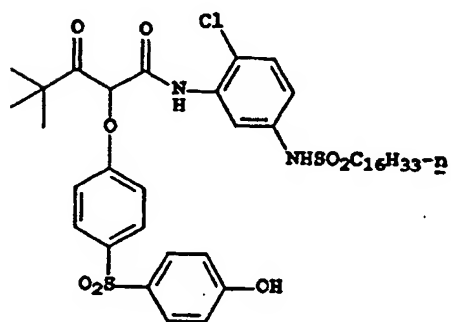
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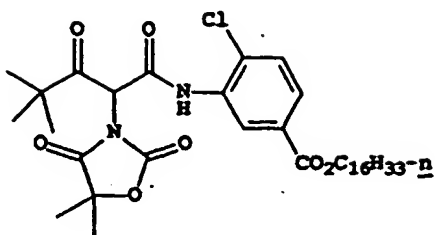
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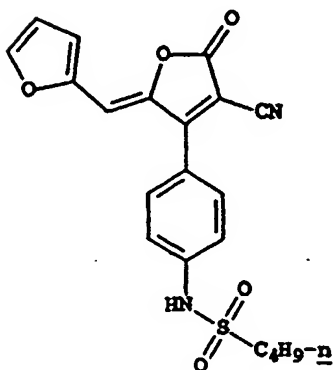
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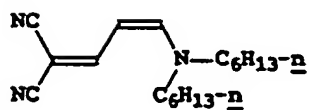
Y-2:



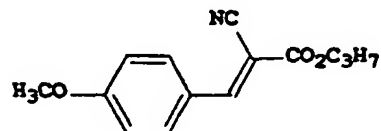
YFD-1:



UV-1:



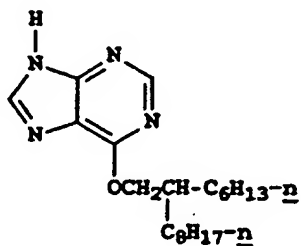
UV-2:



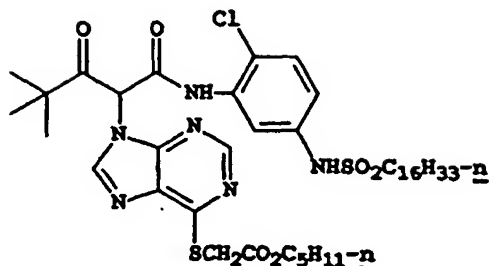
[0101] The structures of the comparative compounds (along with the ClogP values of the released fragment) are as follows:

CC-1:

(7.84)



CC-2:  
(1.89)



[0102] These multilayer coatings were given the indicated stepped exposure and processed in the KODAK FLEXI-COLOR™ (C-41) process as described in *British Journal of Photography Annual*, 1988, pp 196-198. Relative speed or light sensitivity (given in terms of fraction of a stop) was determined by comparing the exposure point +0.15 density units above Dmin to the check position without addenda under the given exposure condition (neutral = all 3 layers exposed at same time; G Only = only the green layer exposed using an appropriate green WRATTEN 74 filter). A larger, more positive number implies increased speed; a negative number implies a loss in sensitivity. Granularity of the green layer in a neutral exposure was determined by the RMS method (see *The Theory of the Photographic Process*, 4<sup>th</sup> Edition, T.H. James, pp 625-628) using a 48 micrometers aperture at the density 1.2 log exposure units from the speed point defined above.

Table 2

Multilayer Results					
Sample	Comp/Inv	Addenda to Layer 9	Speed of Neutral	Speed of G Only	Granularity
ML-1	Comp	-			17.3
ML-2	Comp	Y-1	+0.03	+0.03	18.6
ML-3	Comp	CC-2	-0.37	-0.43	15.5
ML-4	Inv	Coupler A	+0.10	+0.13	17.8

[0103] As demonstrated by the data in Table 2, only the coupler used in the invention gives enhanced photographic response to light while minimizing granularity relative to couplers that release fragments that fall outside the scope of the invention. In a similar experiment as described for the single layers, multilayer coatings with free HSMs like CC-1 showed a increase in speed when added just prior to coating but a speed loss if added directly to the silver halide emulsion and held before coating.

#### Claims

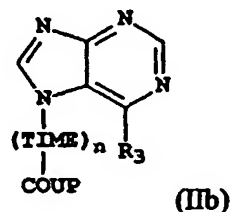
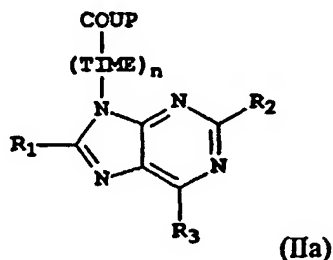
1. A color photographic element comprising at least one light sensitive silver halide emulsion layer having associated therewith a coupler according to Formula I:



wherein:

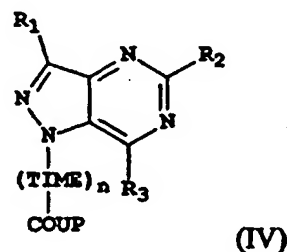
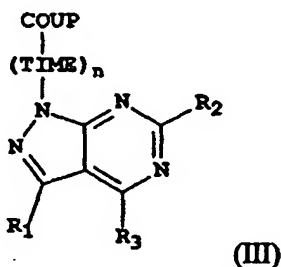
COUP is an organic fragment which reacts with oxidized developer to release  $-(\text{TIME})_n - \text{HSM}$ ,  
 TIME is an optional timing group or linking group which connects HSM to COUP at the site of reaction with oxidized developer,  
 $n=0,1$  or 2, and  
 HSM is a compound having a minimum of three heteroatoms and having a ClogP sufficient to increase the speed of said element compared to the same element without the coupler.

2. The color photographic element of Claim 1 in which the silver halide is silver iodobromide.
3. The color photographic element of Claim 2 in which the silver iodobromide has maximum spectral sensitivity to light with wavelength between 500 and 600 nm.
4. The color photographic element of any one of Claims 1-3 in which HSM is a heterocycle.
5. The color photographic element of Claim 4 in which HSM is a bicyclic nitrogen heterocycle that does not contain any sulfur or oxygen atoms as part of the ring system.
6. The color photographic element of Claim 4 in which HSM of the coupler is a monocyclic nitrogen heterocycle that contains at least two nitrogen atoms and at most, only one oxygen or sulfur atom as part of the ring system.
7. The color photographic element of Claim 1 in which HSM of the coupler is a 1,3,4,6-tetraazaindene (purine) with a ClogP of at least 6.2.
8. The color photographic element of Claim 7 in which the coupler has the structure according to Formula IIa or IIb:



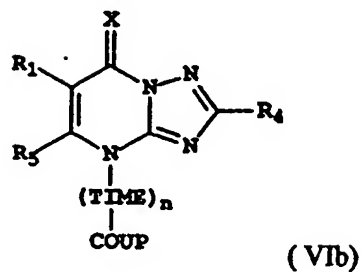
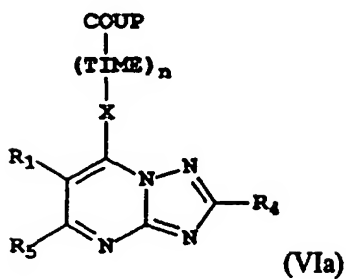
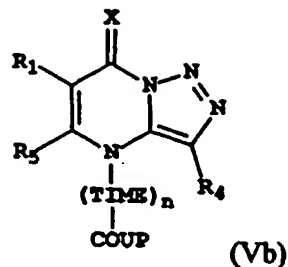
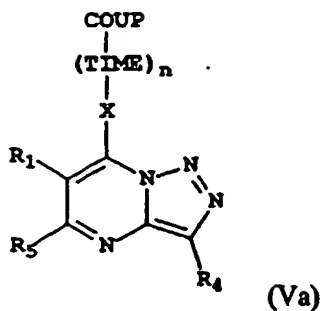
wherein R<sub>3</sub> is an alkyl, aryl, alkyloxy, aryloxy, alkylthio, arylthio, sulfonyl, sulfoxyl, secondary or tertiary amino group, carbonamido group or an sulfonamido group.

9. The color photographic element of Claim 1 in which the coupler has the structure according to Formula III or IV:



wherein R<sub>3</sub> is an alkyl, aryl, alkyloxy, aryloxy, alkylthio, arylthio, sulfonyl, sulfoxyl, secondary or tertiary amino group, carbonamido group or an sulfonamido group.

10. The color photographic element of Claim 1 in which the coupler has a structure selected from Formula Va, Vb, VIa or VIb:



where X is oxygen or sulfur and  $R_4$  and  $R_5$  are independently hydrogen or an alkyl, phenyl, alkyloxy, aryloxy, alkylthio, arylthio, sulfoxide, sulfone, sulfamoyl, halo, cyano, nitro group, an -O-CO- group, an -O-SO<sub>2</sub>- group, a heterocyclic group, a carbonyl group or an amino group.

11. The color photographic element of any one of Claims 1-10 in which the photographic element contains a plurality of layers of the same spectral sensitivity but of differing light sensitivity and the coupler is located in the most light sensitive layer of such layers.

12. The color photographic element of any one of Claims 1-11 wherein the coupler is dispersed in an organic solvent that has a ClogP of 5.0 and a  $\beta$  of 0.4 or more.



European Patent  
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# EUROPEAN SEARCH REPORT

Application Number  
EP 00 20 2461

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
X	PATENT ABSTRACTS OF JAPAN vol. 013, no. 375 (P-921), 21 August 1989 (1989-08-21) & JP 01 129252 A (FUJI PHOTO FILM CO LTD), 22 May 1989 (1989-05-22) * compounds 1-3,5,6,15,16,18,19 * * abstract *	1-6,11	G03C7/305
X	PATENT ABSTRACTS OF JAPAN vol. 009, no. 026 (P-332), 5 February 1985 (1985-02-05) & JP 59 171955 A (KONISHIROKU SHASHIN KOGYO KK), 28 September 1984 (1984-09-28) * abstract * * page 7, compounds 19,23 *	1-6,11	
X	PATENT ABSTRACTS OF JAPAN vol. 011, no. 029 (P-540), 28 January 1987 (1987-01-28) & JP 61 200539 A (FUJI PHOTO FILM CO LTD), 5 September 1986 (1986-09-05) * pages 13-15, compounds 5,6,8,12,19 * * abstract *	1-6,11	
A	EP 0 924 565 A (EASTMAN KODAK CO) 23 June 1999 (1999-06-23) * compound A12 *	1-12	
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			G03C
The present search report has been drawn up for all claims			
Place of search <b>THE HAGUE</b>		Date of completion of the search <b>2 November 2000</b>	Examiner <b>Bolger, W</b>
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons &amp; : member of the same patent family, corresponding document</p>			

EPO FORM 1503 03.82 (P04C01)

**ANNEX TO THE EUROPEAN SEARCH REPORT  
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EP 00 20 2461

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on  
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02-11-2000

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